Nature’s own Cosmetics

User manual

Revised : 2017.12.21 (Rev 02)

Powder Servo Press Machine

Model No : PSR-4800D

SERIAL No. 17E-PSR48-2064

Leidex

○ SAFETY INSTRUCTION

Please read this manual before operation and try to operate the machine with safety caution.

For safety matter, we categorized “**Danger**” and “**Caution**”.

Danger Improper operation may result serious danger which may cause serious injuries or death.

Caution Improper operation may result dangerous case which may cause body injuries and/or property damages.

Any listed caution may cause serious result so please read carefully and follow the instruction for safety matter.

Please hand this manual to end-user so he/she can review the instruction anytime, also keep this manual at safe place with extra care.

○ SAFETY WARNINGS

	1. Any safety device related to this machine shall not be modified. 2. High Voltage of electricity flows inside of electronic panel so please do not operate while opened. 3. During operation, do not insert hands, arms and other parts of human body into machine. In emergency situation, please stop the machine first and take further actions related to machine’s malfunction. Please do not use human body to check malfunction of machine. 4. Besides the repair of machine and other operation, please turn off the power and do proper work. 5. Please check the linear horizontality, power voltage and proper air pressure when install the machine. 6. Please Do Not modify PLC programs and other operating switches. 7. Please place the spare kits into the safety place. 8. Please always read this manual before operation. 9. Please stop the machine and re-operate the machine after proper actions if any error happens.

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  1) Specification
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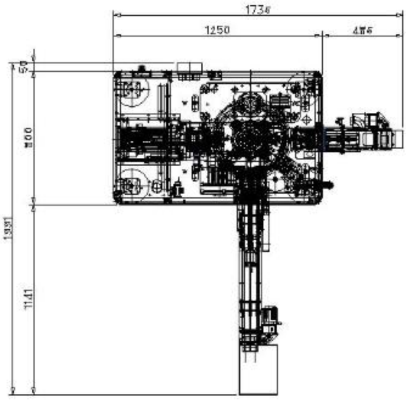
1. Specification

1) Specification

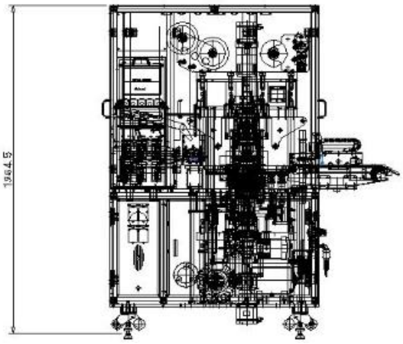
Production type	Press Servo Type , Rotary Type
Operator	1~2 people
Production capacity	Up to 4,800/1,200 pcs/h
Turn table cavity	Shadow 32EA / Pact 8EA
Hopper volume	15 ℓ
Power supply	2.5kw, 12A, AC 220V /3Ph, 60㎐
Frequency	60 Hz
Compressed air	Over 5 kg/cm² (BAR)
Power consumption	5 kw
Main control unit	PLC (Made by YASKAWA, JAPAN)
Operating type	Touch Screen (Made by EASY VIEW, TAIWAN)
Control type	Servo Motor (Made by YASKAWA, JAPAN)
	Pneumatic cylinder (Made by SMC, JAPAN)
	INDEX (Made by SANKYO, JAPAN)
	AC/DC Motor (Made by SPG, KOREA)
Machine size	2035(W) x 1740(D) x 1920(H)㎜

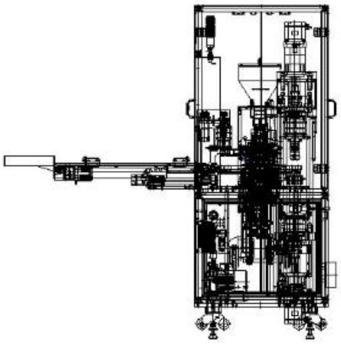
1. Specification

2) Dimensions

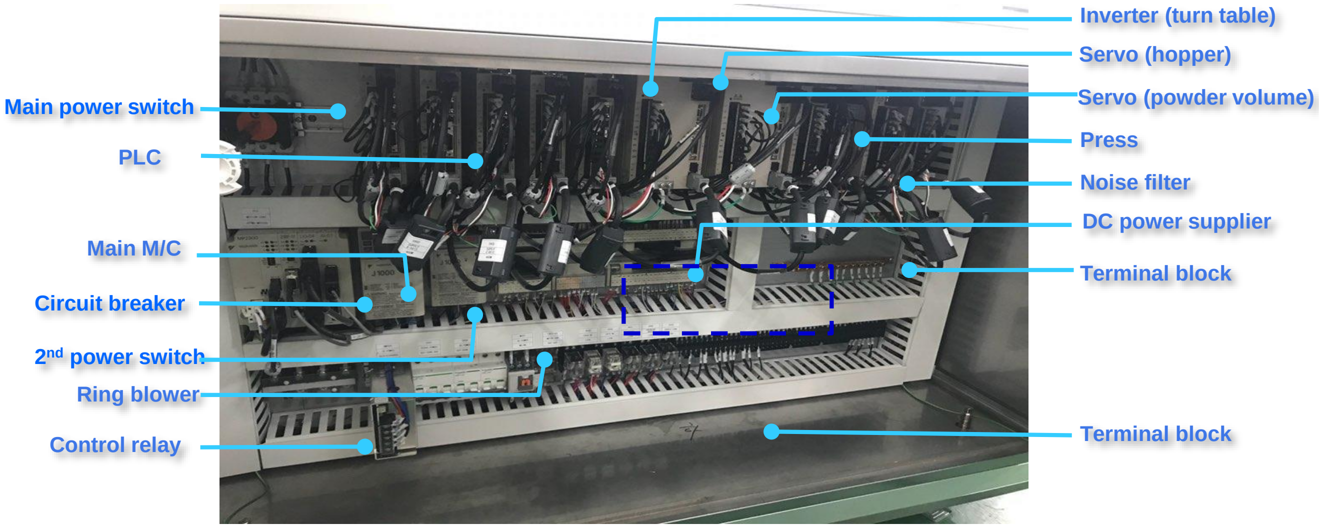


1738
1250
488
50
800
1991
1141





3) Main power box



Inverter (turn table)
Servo (hopper)
Main power switch
Servo (powder volume)
PLC
Press
Noise filter
DC power supplier
Main M/C
Terminal block
Circuit breaker
2nd power switch
Ring blower
Control relay
Terminal block

2. Installation

1) Surrounding environment(distance)

- Please have minimum distance between machines and walls.

Distance from rear wall : 1000 mm

Distance from right wall : 500 mm

Distance from left wall : 500 mm

2) Level of machine

- Check the horizontality level of machine using leveling device.(1/100mm)

3) Power connection

- Input power: AC 220v, 3 Phase + N
  Frequency: 60 Hz
  Electronic consumtion: 5 Kw

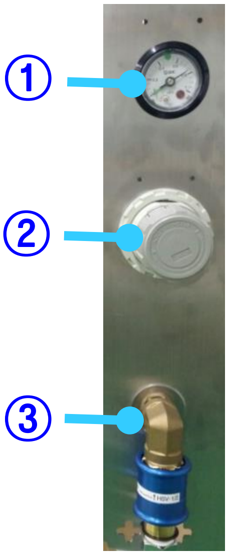
Please connect electronic plug to terminal.

- Please check if there is broken or loose part after unpacking.
As soon as you find broken parts, contact Leidex for machine detail.

- Please get advice from Electrician.
- Ground under 10-ohm.
- Please check the first voltage level after connecting power.

2. Installation

4) Air connection

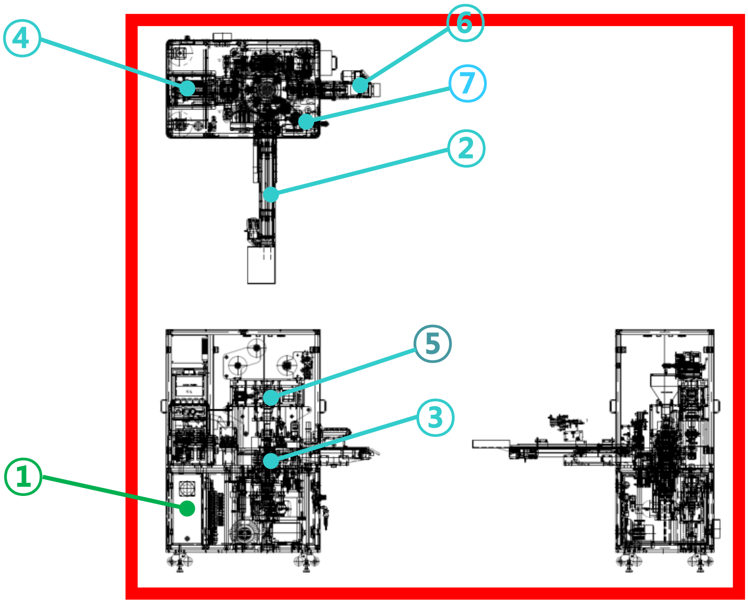
No.	Description
	The unit in picture is for purify supplied air and convert proper pressure for machine.
	Detail
	① Gauge for pressure of air ② Pressure controller of supplied air ③ Connect air pressure to No. 3 by hose. By slide valve up/down, operator can control air supplying/disconnect.

5) Installation Environment

	●Avoid high temperature and humidity. ● Recommended Temperature: 18 ~ 28℃ ● Other Environment : Avoid the place where has corrosiveness, inflammable, oily and dust.

3. Structure

1) Lay-out

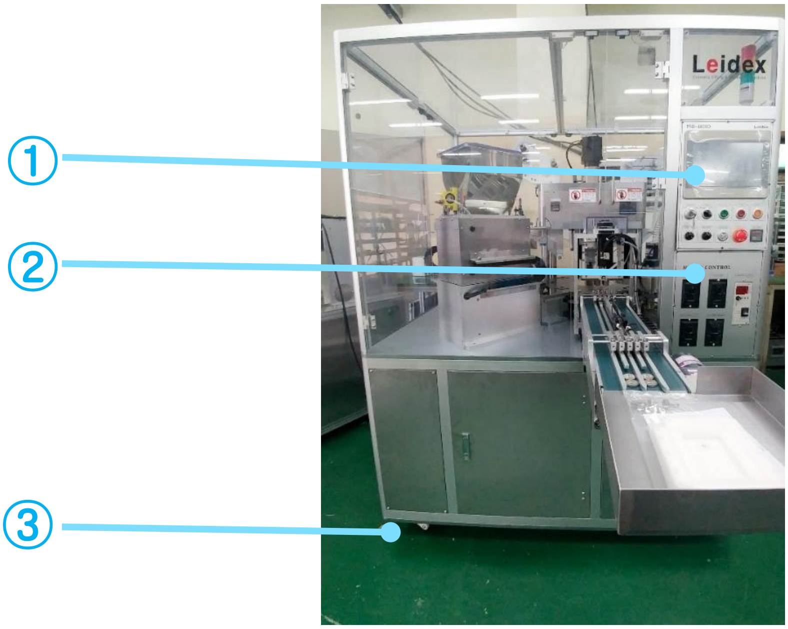


NO	Name	Description
1	Frame	Aluminum profile
2	Input conveyor	Transferring aluminum pan to machine's turn table
3	Main driving	For rotating turn table by index
4	Hopper	For powder feeding to aluminum pan
5	Servo press	Powder press part with cloth
6	Out conveyor	Transferring pressed powder from machine to outside
7	Cleaning part	After discharging products, clean table and remove dust .

Please make clean production site for safety and keep safety in mind during machine running.

3. Structure

2) Frame



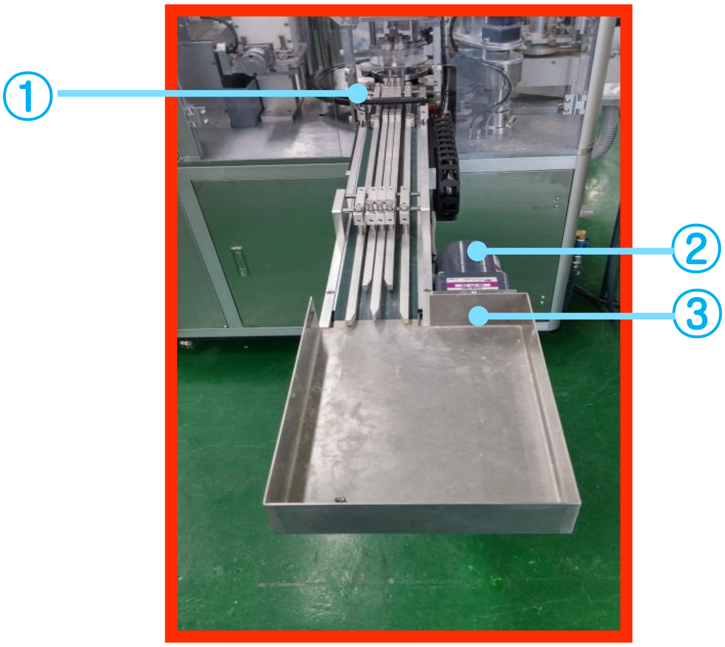
● Composition

Name	Description
① OP BOX	Touch screen & button for machine operation
② CONTROL BOX	Electronic main supply box
③ Caster / Foot	Wheel for easy control machine’s movement & height

Do not open safety door when machine is running.

3. Structure

3)In-conveyor



● Function

- Conveyor belt to supply aluminum pan to machine.

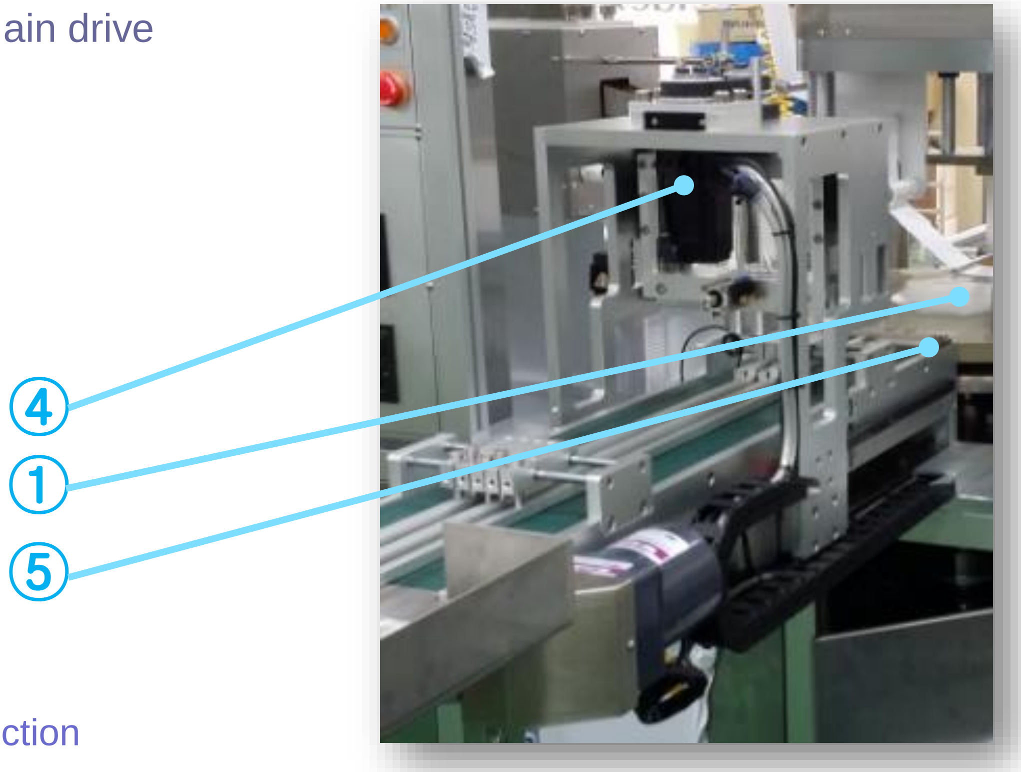
● Composition

Name	Description
① Godet Guide	Guide for arranging aluminum pans before being supplied to turn table.
② AC Motor	Rotates conveyor belt to supply pans to the turn-table
③ Loading dish	For operator's easy pan supplying, stand by position for pans.

Do not open safety door when machine is running.

3. Structure

4) Main drive



- Function

- Index rotates the turn table to produce pressed powder

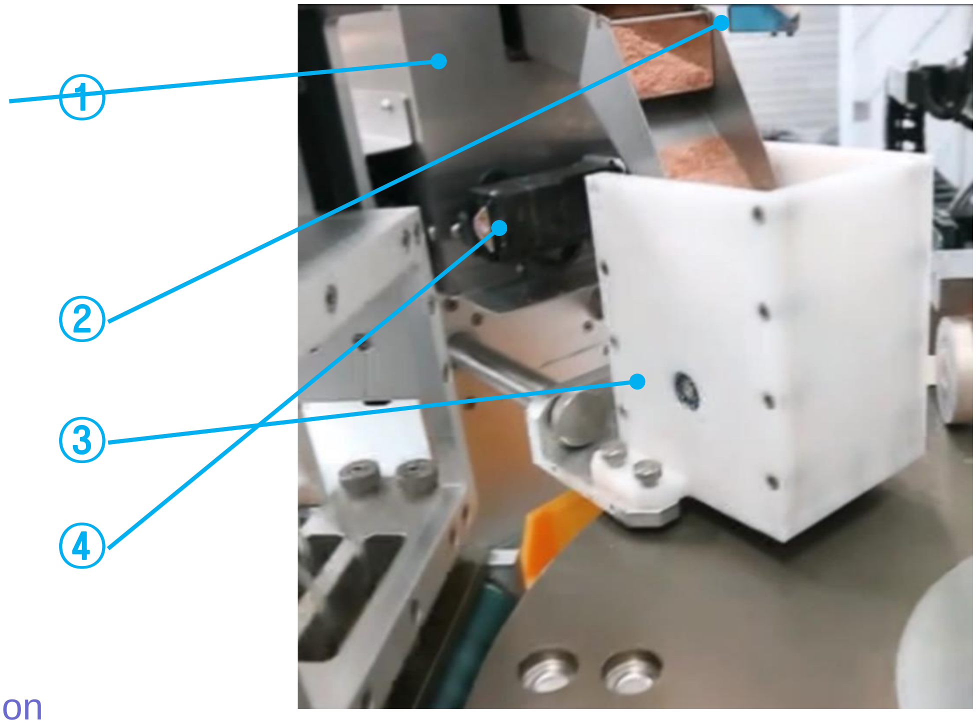
- Composition

Name	Description
① Turn table	Turn table(8 division)
② Index	Transferring turn table(1/8) to each unit for each part (under turn table)
③ Geared motor	Motor to rotate turn table (under turn table)
④ Servo	Device for pushing aluminum pans by moving Up and Down
⑤ Pusher guide	Device for pressing the pans supplied to the mold

Do not open safety door when machine is running.

3. Structure

5) Hopper



- **Function**

- Unit for feeding powder to aluminum pan

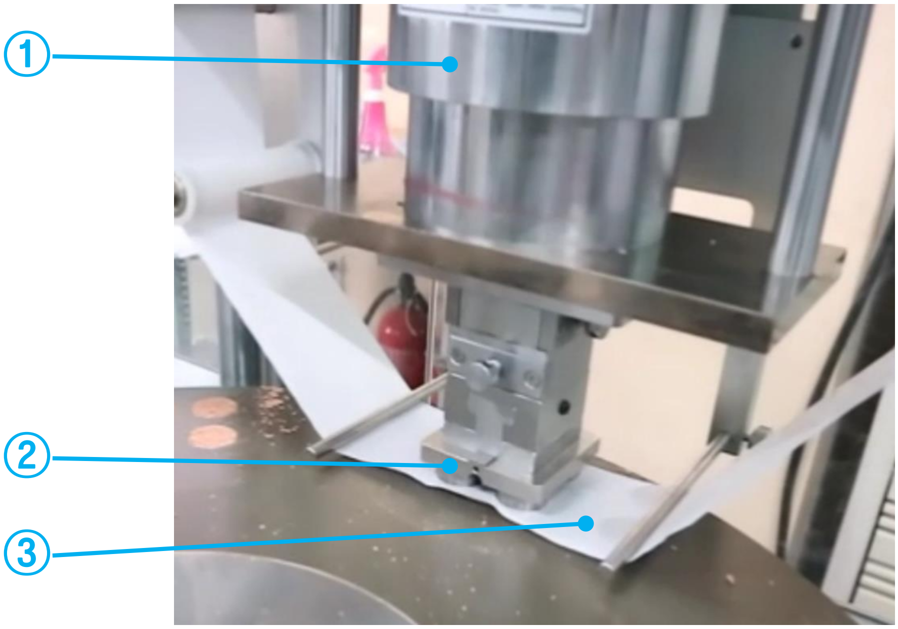
- **Composition**

Name	Description
① Aluminum hopper	Stainless Steel, 1.5 Liters hopper
② Sensor	Sensor to check powder amount in action hopper
③ Action hopper	Moving(action) hopper to feed powder to aluminum pan directly . Easy dismantle structure for cleaning
④ Servo motor	Adjusts the speed and rotation of the impeller

Do not open safety door when machine is running.

3. Structure

6) Servo press



● Function

- Press supplied powders by Servo motor.

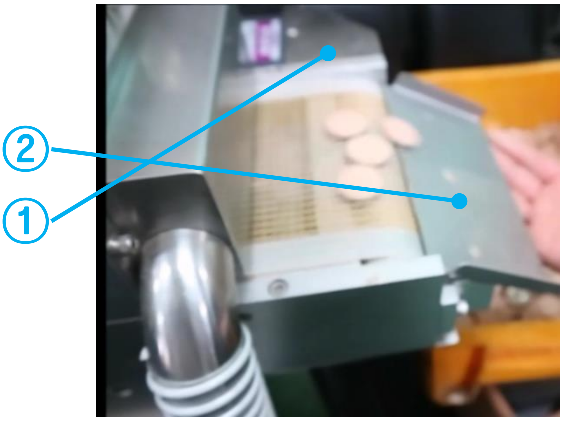
● Composition

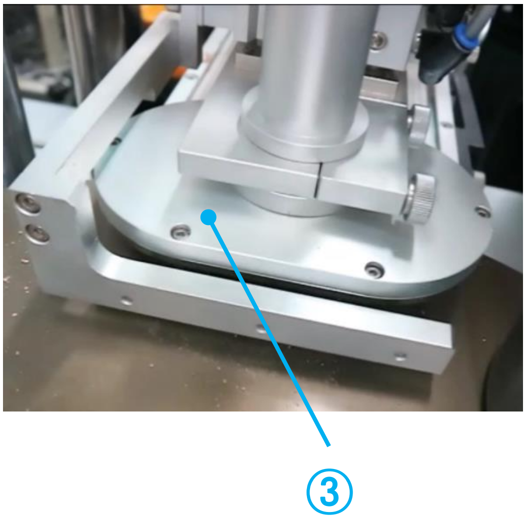
Name	Description
① Servo	Punch move up/down by Servo
② Punch	Punch which press powder directly
③ Cloth	Cloth for pressed powder surface

Do not open safety door when machine is running.

3. Structure

7) Out-conveyor





Function

– Discharging conveyor for pressed products.

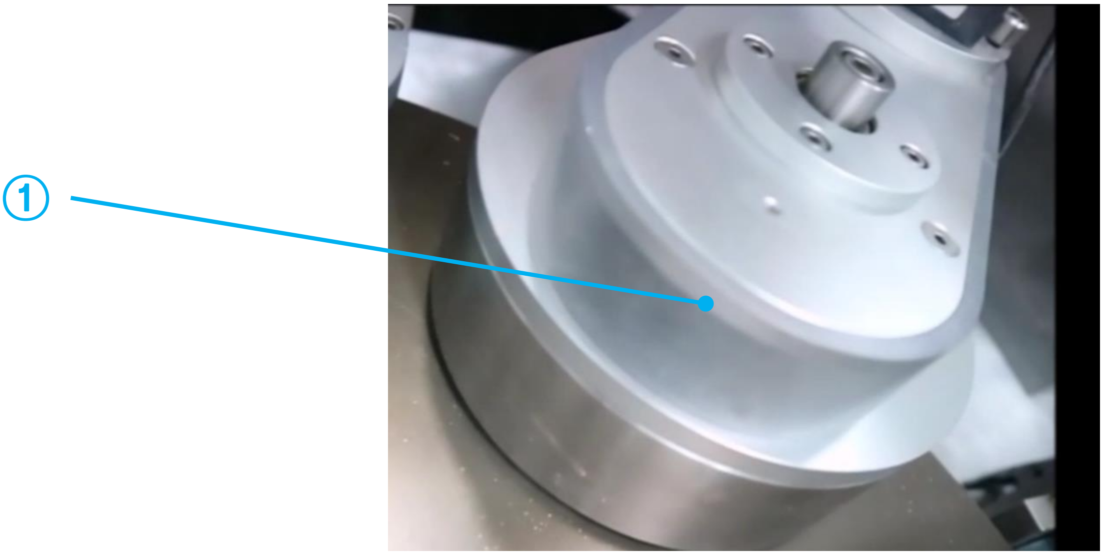
Composition

Name	Description
① Motor cover	Cover to prevent dust inside the motor for safety
② Discharging guide	Chute for discharging powder
③ Discharge	Pick up the godet

Do not open safety door when machine is running.

3. Structure

8) Cleaning unit



- **Function**

– Cleans dust in the hole after discharging aluminum pan.

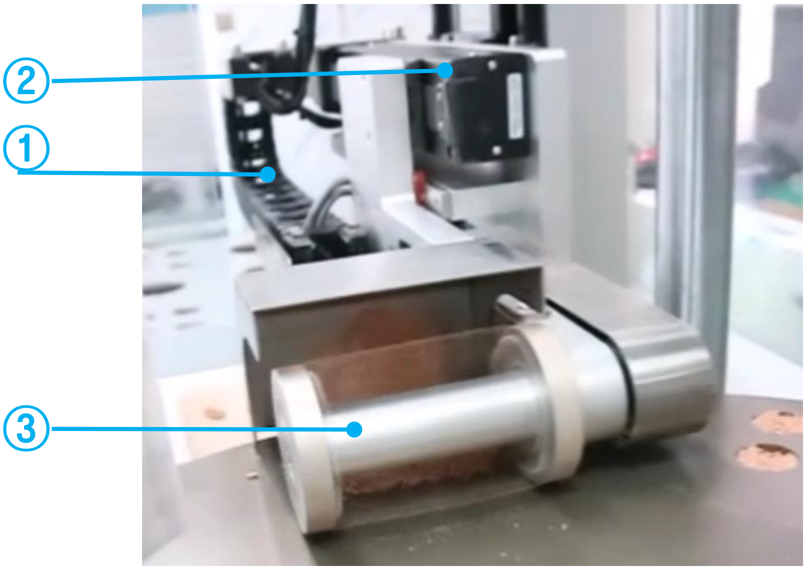
- **Composition**

Name	Description
① Brush & vacuum	Cleaning the powder

Do not open safety door when machine is running.

3. Structure

9) Wire Cutting



● Function

– Cleans dust in the hole after discharging aluminum pan.

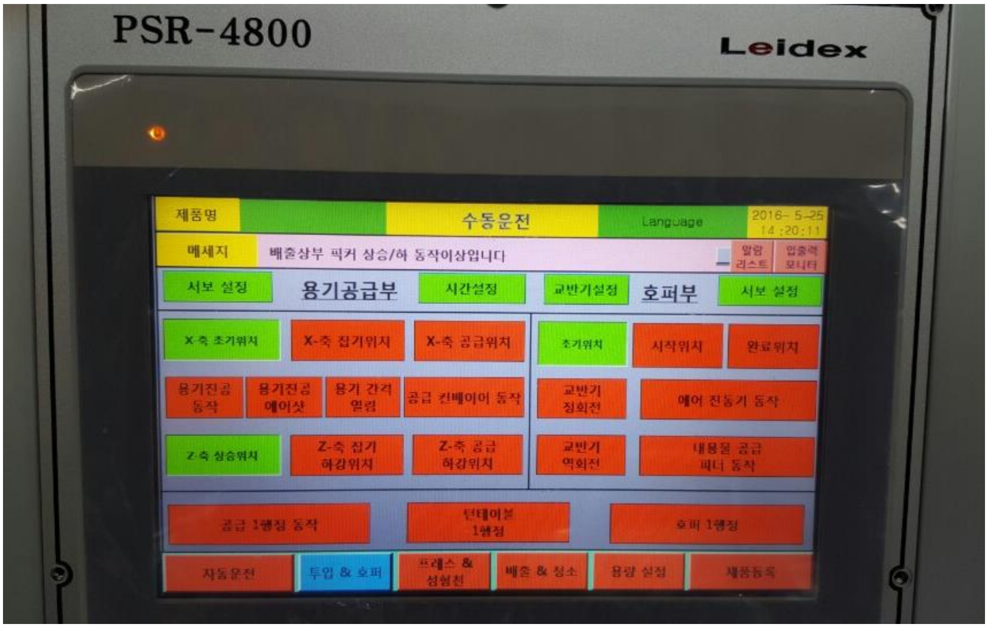
● Composition

Name	Description
① Bellows cover	To emit finished products on out-conveyor
② cylinder	Emit finished product
③ Wire cutting	Cutting the surface of powder

Do not open safety door when machine is running.

4. Operation Panel

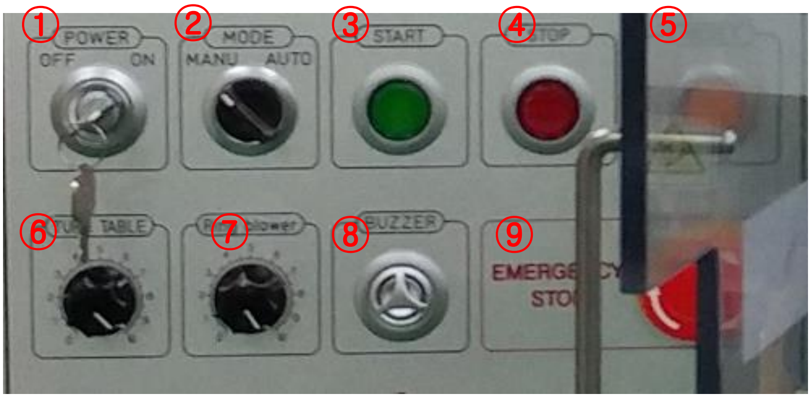
1) Touch screen


PSR-4800
Leidex
제품명
수동운전
Language
2016- 5-25
14 :20:11
메세지
알람 리스트
입출력 모니터
서보 설정
용기공급부
시간설정
교반기설정
호퍼부
서보 설정
X-축 초기위치
X-축 집기위치
X-축 공급위치
초기위치
시작위치
완료위치
용기진공 동작
용기진공 에어샷
용기 간격 열림
공급 컨베이어 동작
교반기 정회전
에어 진동기 동작
Z-축 상승위치
Z-축 집기 하강위치
Z-축 공급 하강위치
교반기 역회전
내용물 공급 피더 동작
공급 1행정 동작
턴테이블 1행정
호퍼 1행정
자동운전
투입 & 호퍼
프레스 & 성형천
배출 & 청소
용량 설정
제품등록

배출상부 픽커 상승/하 동작이상입니다

4. Operation Panel

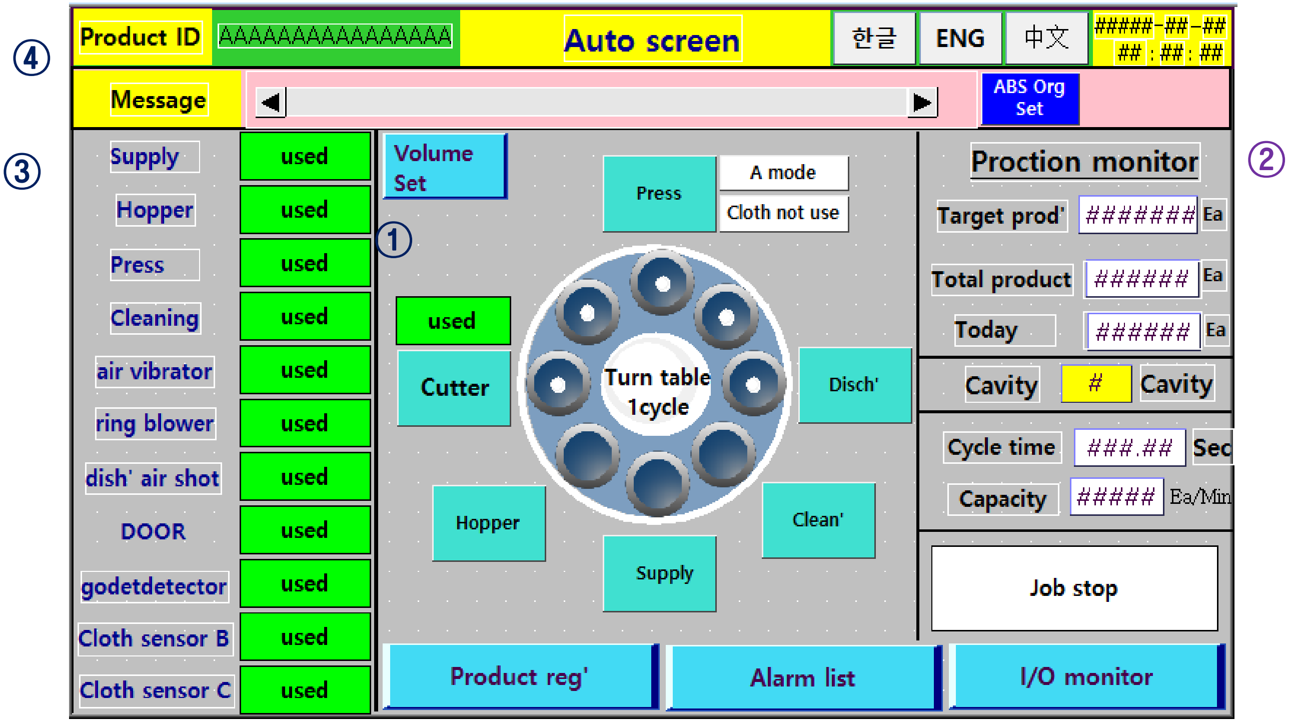
2) Switch



NO	Name	Description
1	POWER	Main power On/Off and blocking external power connection
2	MODE	Change mode of machine. MANUAL – Able to run each unit individually. AUTO – Able to run machine automatically, following setting point.
3	START	When automatic preparation is completed, the START button flashes green and if you press the button immediately, you can select the desired operation.
4	STOP	Stop all units after current working. If the operator has to stop the machine urgently, press EMERGENCY STOP.
5	RESET	Press RESET to cancel abnormal situation.
6	SPEED CONTORLLER (Turn table)	Controlling speed of turn table
7	RING BLOWER	Controlling power of ring blower which sucks air out side
8	Buzzer	Alarm sound of abnormal working
9	EMERGENCY STOP	Press EMERGENCY BUTTON when there is an urgent situation. Ex) Safety, abnormal running of the machine Cancel EMERGENCY by turning the button left to right

5. Touch screen

1) Auto screen


④
③
①
②
Auto screen
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
Volume Set
Press
Cutter
Turn table 1cycle
Disch'
Hopper
Clean'
Supply
Proction monitor
Job stop
Product reg'
Alarm list
I/O monitor

Product ID AAAAAAAAAAAAAAAA

Supply used
Hopper used
Press used
Cleaning used
air vibrator used
ring blower used
dish' air shot used
DOOR used
godetdetector used
Cloth sensor B used
Cloth sensor C used

A mode
Cloth not use
Cutter used

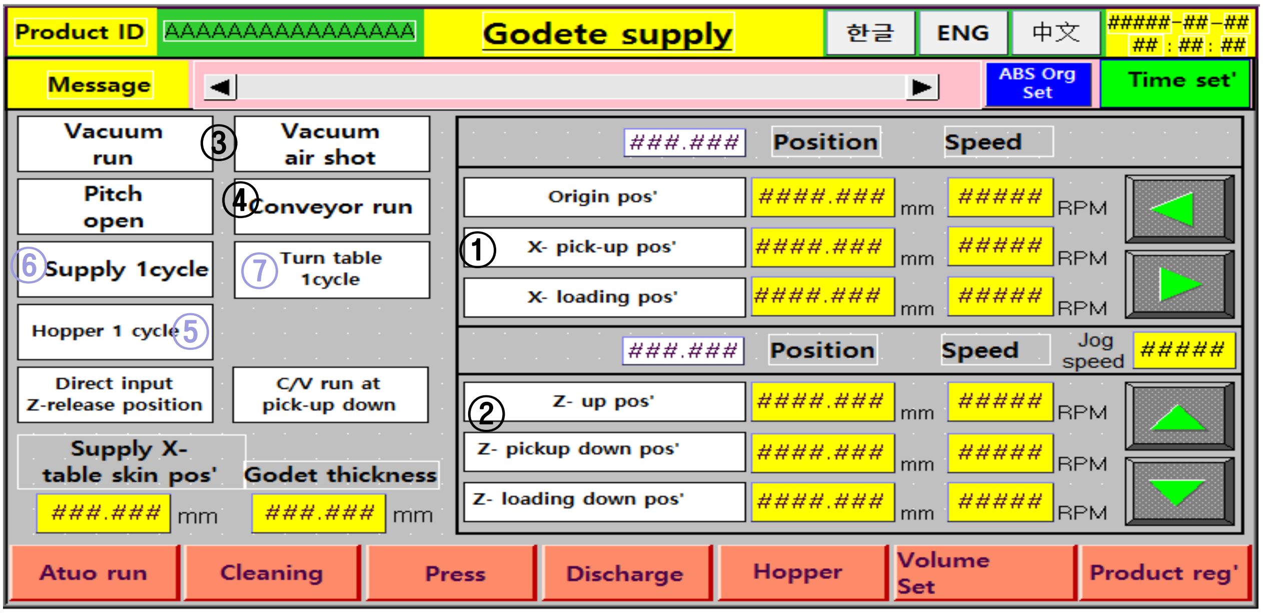
Target prod' ####### Ea
Total product ###### Ea
Today ###### Ea
Cavity # Cavity
Cycle time ###.## Sec
Capacity ##### Ea/Min

Menu	Description
① Production state	Checking the movement of aluminum pan Operator can check where the problem has caused.
② Production monitor	Setting target amount & checking current production capacity
③Use/No use	When auto mode, operator can choose to use or not to use each unit.
④ Error message	Error message pop up when machine has problem.

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

2) Manual mode


Product ID
AAAAAAAAAAAAAAAAA
Godete supply
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
Time set'
Vacuum run
③
Vacuum air shot
Pitch open
④
Conveyor run
⑥
Supply 1cycle
⑦
Turn table 1cycle
Hopper 1 cycle
⑤
Direct input Z-release position
C/V run at pick-up down
Supply X-table skin pos'
Godet thickness
###.###
mm
###.###
Position
Speed
Origin pos'
①
X- pick-up pos'
X- loading pos'
####.###
#####
RPM
Jog speed
②
Z- up pos'
Z- pickup down pos'
Z- loading down pos'
Atuo run
Cleaning
Press
Discharge
Hopper
Volume Set
Product reg'

Menu	Description
(1) Godet supply	① X-axis : Move X-axis of gripper of aluminum pan ② Z-axis : Move Y-axis of gripper of aluminum pan ③ Vacuum pad : Vacuum On/Off & control pitch of gripper ④ Conveyor run : Turning On/Off of In-conveyor motor
(2) Hopper	⑤ Hopper 1 cycle : Run action hopper 1 time
(3) Cycle run	⑥ Supply 1 cycle : With setting point, run powder feeding unit 1 time. ⑦ Turn table 1 cycle : Move turn table 1 section.

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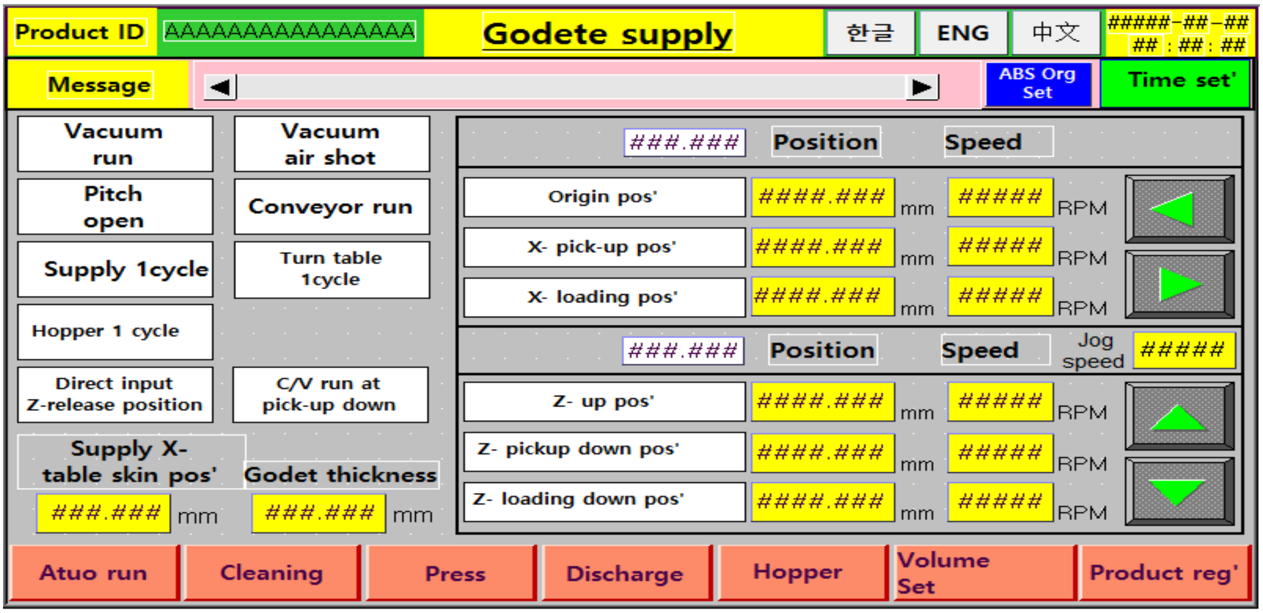
5. Touch screen

2) Manual mode

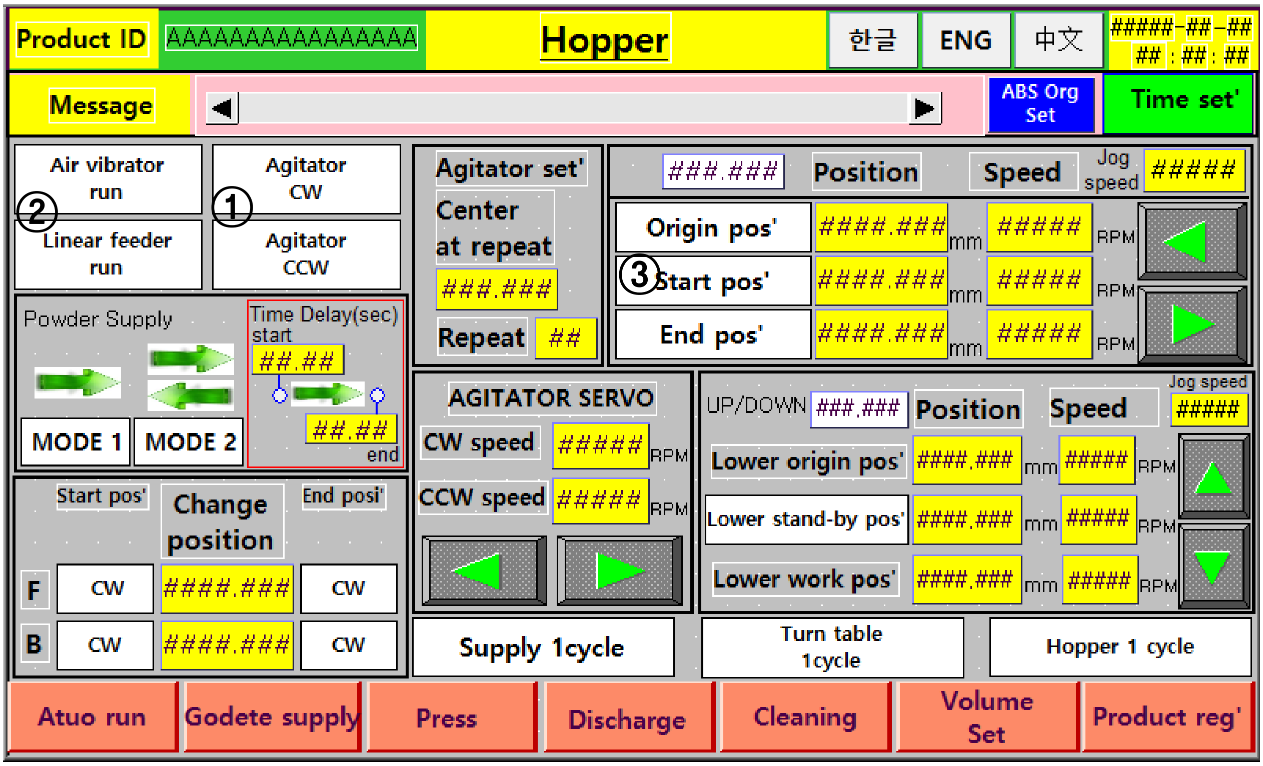

Product ID
AAAAAAAAAAAAAAAAA
Godete supply
한글
ENG
中文
#####-##-##
## : ## : ##
Message
◀
▶
ABS Org Set
Time set'
Vacuum run
Vacuum air shot
Pitch open
Conveyor run
Supply 1cycle
Turn table 1cycle
Hopper 1 cycle
Direct input Z-release position
C/V run at pick-up down
Supply X-table skin pos'
Godet thickness
###.### mm
###.### mm
###.###
Position
Speed
Origin pos'
####.### mm
##### RPM
X- pick-up pos'
####.### mm
##### RPM
X- loading pos'
####.### mm
##### RPM
###.###
Position
Speed
Jog speed
#####
Z- up pos'
####.### mm
##### RPM
Z- pickup down pos'
####.### mm
##### RPM
Z- loading down pos'
####.### mm
##### RPM
Atuo run
Cleaning
Press
Discharge
Hopper
Volume Set
Product reg'

Menu	Description
(1) Godet supply servo setting	Designate each position of picker by inputting point
(2) Godet supply time setting	Designate delay time for picker, hopper and conveyor.

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

2) Manual mode


Product ID
AAAAAAAAAAAAAAAA
Hopper
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
Time set'
Air vibrator run
Agitator CW
②
①
Linear feeder run
Agitator CCW
Powder Supply
Time Delay(sec)
start
##.##
##.##
end
MODE 1
MODE 2
Start pos'
Change position
End posi'
F
CW
####.###
CW
B
CW
####.###
CW
Agitator set'
Center at repeat
###.###
Repeat
##
###.###
Position
Speed
Jog speed
#####
Origin pos'
####.###
mm
#####
RPM
③
Start pos'
####.###
mm
#####
RPM
End pos'
####.###
mm
#####
RPM
AGITATOR SERVO
CW speed
#####
RPM
CCW speed
#####
RPM
UP/DOWN
###.###
Position
Speed
Jog speed
#####
Lower origin pos'
####.###
mm
#####
RPM
Lower stand-by pos'
####.###
mm
#####
RPM
Lower work pos'
####.###
mm
#####
RPM
Supply 1cycle
Turn table 1cycle
Hopper 1 cycle
Atuo run
Godete supply
Press
Discharge
Cleaning
Volume Set
Product reg'

Menu	Description
(3) Hopper Agitator setting	Choose direction of rotation of agitator in action hopper ① Agitator rotation : Rotate agitator Normal/Reversed ② Powder feeding : Big &action hopper working for powder feeding ③ Hopper Position : Move hopper to each position.
(4) Hopper Servo setting	Designate each position for action hopper. (* Please use jog to change value)

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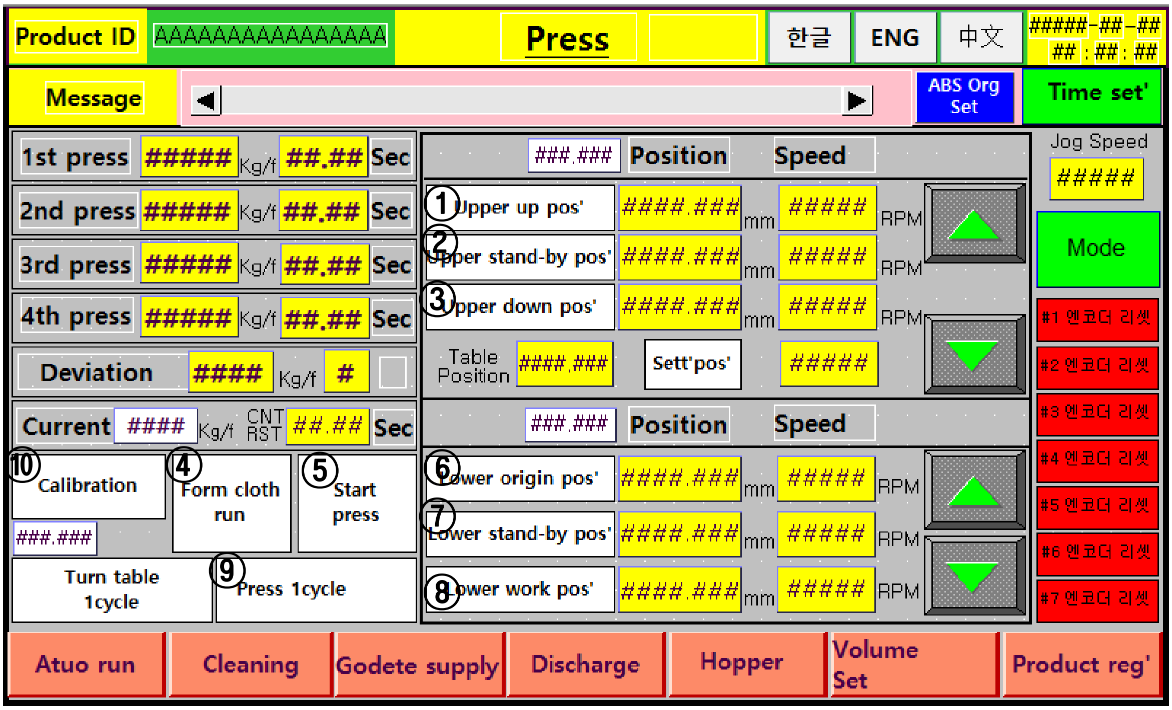
5. Touch screen

2) Manual mode

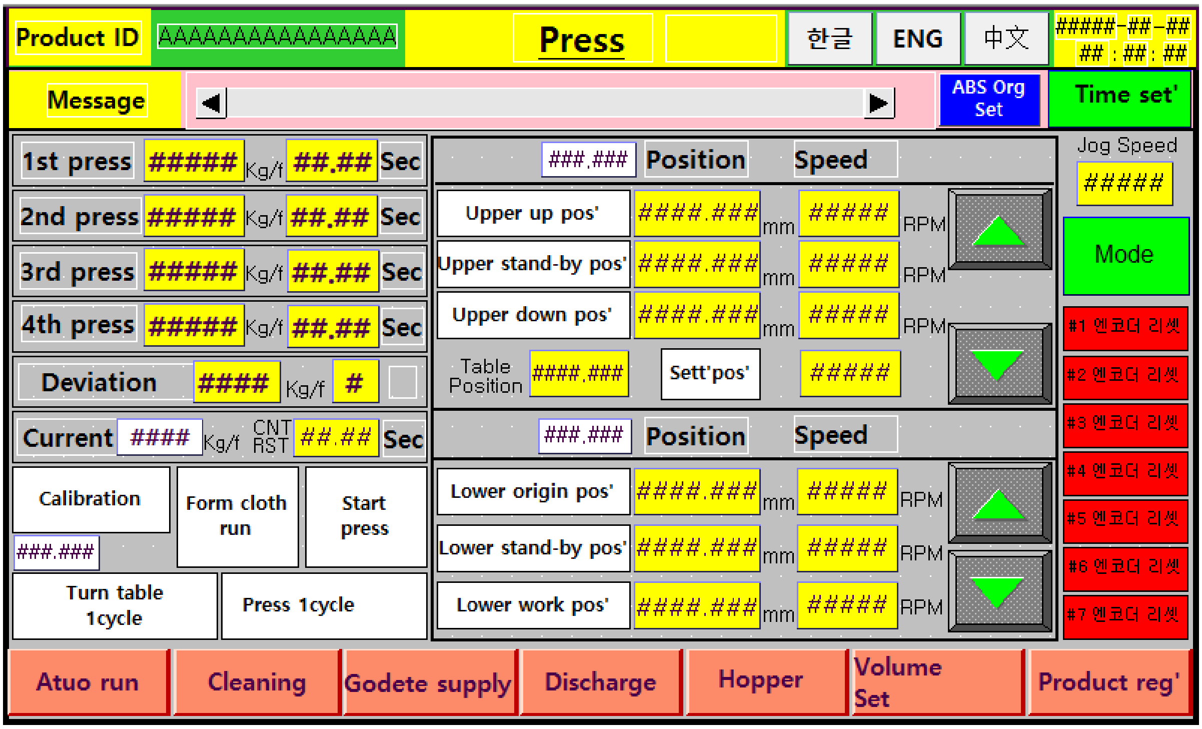

Product ID
AAAAAAAAAAAAAAAA
Press
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
Time set'
1st press ##### Kg/f ##.## Sec
2nd press ##### Kg/f ##.## Sec
3rd press ##### Kg/f ##.## Sec
4th press ##### Kg/f ##.## Sec
Deviation #### Kg/f #
Current #### Kg/f CNT RST ##.## Sec
⑩ Calibration
###.###
④ Form cloth run
⑤ Start press
Turn table 1cycle
⑨ Press 1cycle
###.### Position Speed
① Upper up pos' ####.### mm ##### RPM
② Upper stand-by pos' ####.### mm ##### RPM
③ Upper down pos' ####.### mm ##### RPM
Table Position ####.### Sett'pos' #####
###.### Position Speed
⑥ Lower origin pos' ####.### mm ##### RPM
⑦ Lower stand-by pos' ####.### mm ##### RPM
⑧ Lower work pos' ####.### mm ##### RPM
Jog Speed
#####
Mode
#1 엔코더 리셋
#2 엔코더 리셋
#3 엔코더 리셋
#4 엔코더 리셋
#5 엔코더 리셋
#6 엔코더 리셋
#7 엔코더 리셋
Atuo run
Cleaning
Godete supply
Discharge
Hopper
Volume Set
Product reg'

Menu	Description
(5) Press part	① Upper up pos' : Moving to origin position of upper press part ② Upper stand by pos' : Moving to ready position of upper press part ③ Upper down pos' : Moving to press position of upper press part ④ Form cloth run : Winding cloth roll 1 time ⑤ Start pressure : Press of punch 1 time following setting point ⑥ Lower origin pos' : Moving to origin position of lower press part ⑦ Lower stand-by pos' : Moving to ready position of lower press part ⑧ Lower pressure pos' : Moving to press position of lower press part ⑨ Press 1 cycle : Upper & Lower part's press 1 time following setting point ⑩ Pressure checking : Display current pressure of press part.

⚠ **Do not use sharp tool for touch screen. Screen might get damage.**

5. Touch screen

2) Manual mode

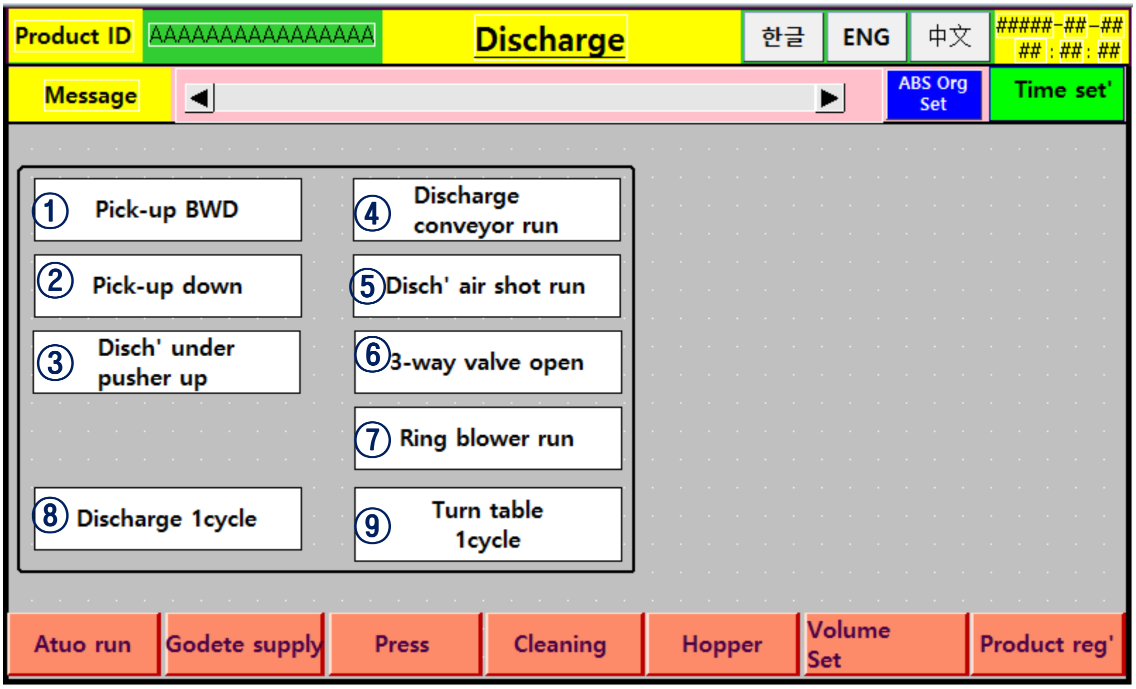

Product ID
AAAAAAAAAAAAAAAAA
Press
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
Time set'
1st press ##### Kg/f ##.## Sec
2nd press ##### Kg/f ##.## Sec
3rd press ##### Kg/f ##.## Sec
4th press ##### Kg/f ##.## Sec
Deviation #### Kg/f #
Current #### Kg/f CNT RST ##.## Sec
Calibration
###.###
Form cloth run
Start press
Turn table 1cycle
Press 1cycle
###.### Position Speed
Upper up pos' ####.### mm ##### RPM
Upper stand-by pos' ####.### mm ##### RPM
Upper down pos' ####.### mm ##### RPM
Table Position ####.### Sett'pos' #####
###.### Position Speed
Lower origin pos' ####.### mm ##### RPM
Lower stand-by pos' ####.### mm ##### RPM
Lower work pos' ####.### mm ##### RPM
Jog Speed
#####
Mode
#1 엔코더 리셋
#2 엔코더 리셋
#3 엔코더 리셋
#4 엔코더 리셋
#5 엔코더 리셋
#6 엔코더 리셋
#7 엔코더 리셋
Atuo run
Cleaning
Godete supply
Discharge
Hopper
Volume Set
Product reg'

Menu	Description
(6) Press Servo setting	Designate each position for action hopper. (* Please use jog to change value)
(7) Press Pressure setting	Designate each position & time for servo press

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

2) Manual mode

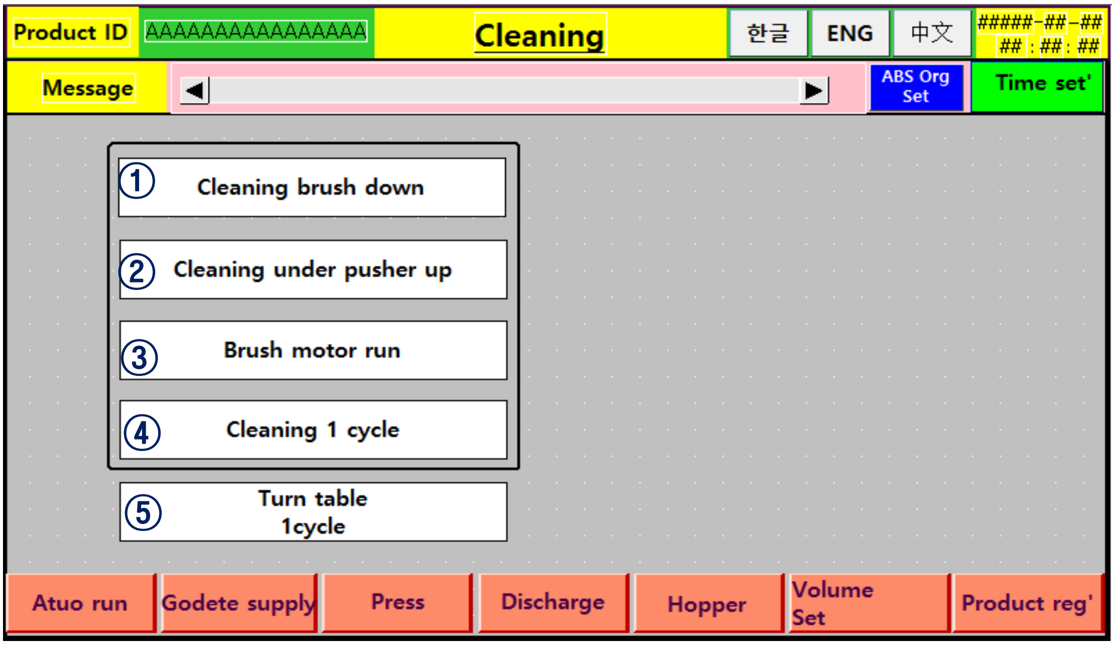

Product ID
AAAAAAAAAAAAAAAA
Discharge
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
Time set'
① Pick-up BWD
② Pick-up down
③ Disch' under pusher up
④ Discharge conveyor run
⑤ Disch' air shot run
⑥ 3-way valve open
⑦ Ring blower run
⑧ Discharge 1cycle
⑨ Turn table 1cycle
Atuo run
Godete supply
Press
Cleaning
Hopper
Volume Set
Product reg'

Menu	Description
(8) Discharge	① Picker FWD/BWD: Move cylinder of discharging forward/backward. ② Picker UP/DOWN : Discharging picker UP/DOWN. ③ Disch’ under pusher UP/DOWN : Pounder in discharging part UP/DOWN ④ Discharge conveyor ON/OFF: Conveyor of discharging ON/OFF. ⑤ Disch’ air shot : Air shot on out-conveyor ON/OFF . ⑥ 3-Way Valve ON/OFF: 3 way valve of vacuum ON/OFF . ⑦ Ring blower ON/OFF : Ring blower in discharging picker ON/OFF. ⑧ Discharge 1 cycle : Run discharging unit 1 time following setting point. ⑨ Turn table 1 cycle : Move turn table 1 section

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

2) Manual mode

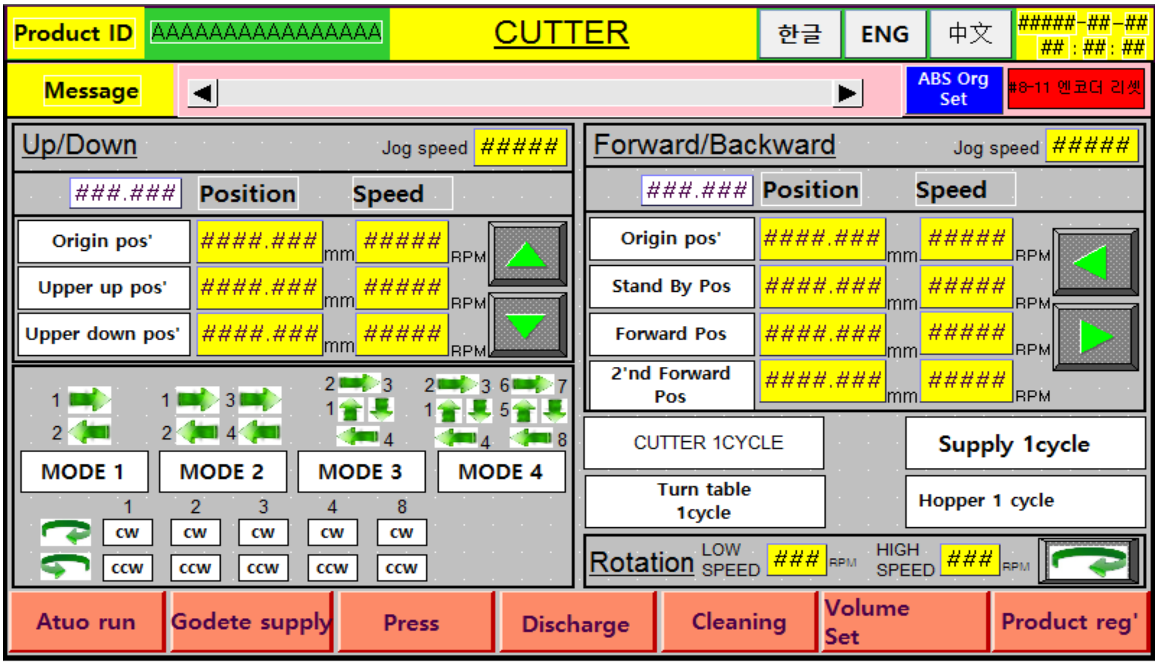

Product ID
AAAAAAAAAAAAAAAA
Cleaning
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
Time set'
① Cleaning brush down
② Cleaning under pusher up
③ Brush motor run
④ Cleaning 1 cycle
⑤ Turn table 1cycle
Atuo run
Godete supply
Press
Discharge
Hopper
Volume Set
Product reg'

Menu	Description
(9) Cleaning	① Cleaning brush UP/DOWN : Cleaning brush move UP/DOWN in unit.. ② Cleaning under pusher UP/DOWN : Pounder in cleaning part UP/DOWN. ③ Brush motor ON/OFF : Brush rotation ON/OFF. ④ Cleaning 1 cycle : Run cleaning part 1 time following setting point. ⑤ Turn table 1 cycle : Move turn table 1 section

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

2) Manual mode

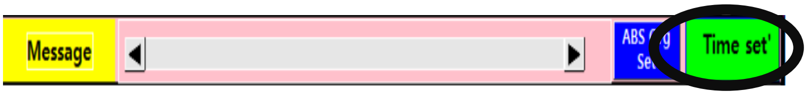

Product ID
AAAAAAAAAAAAAAAAA
CUTTER
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
#8-11 엔코더 리셋
Up/Down
Jog speed #####
###.###
Position
Speed
Origin pos'
Upper up pos'
Upper down pos'
####.### mm
##### RPM
Forward/Backward
Jog speed #####
###.###
Position
Speed
Origin pos'
Stand By Pos
Forward Pos
2'nd Forward Pos
####.### mm
##### RPM
MODE 1
MODE 2
MODE 3
MODE 4
1 2 3 4 8
CW
CCW
CUTTER 1CYCLE
Supply 1cycle
Turn table 1cycle
Hopper 1 cycle
Rotation
LOW SPEED ### RPM
HIGH SPEED ### RPM
Atuo run
Godete supply
Press
Discharge
Cleaning
Volume Set
Product reg'

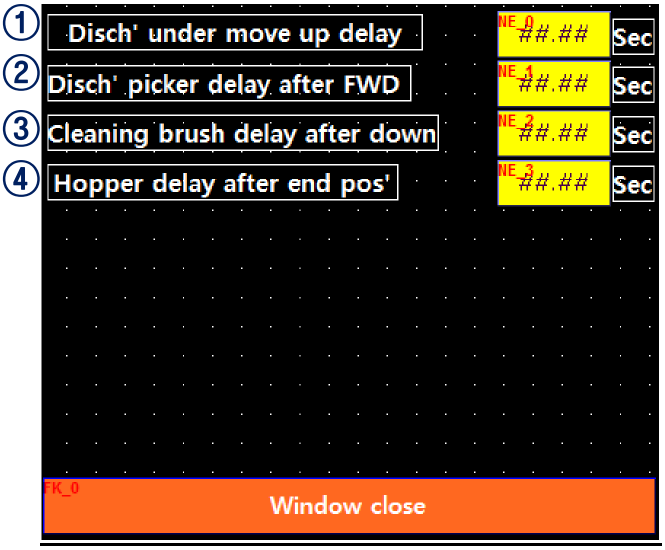
Menu	Description
(10) Cutter	Adjust the cutting part.

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

2) Manual mode


Message
ABS Cfg Set
Time set'

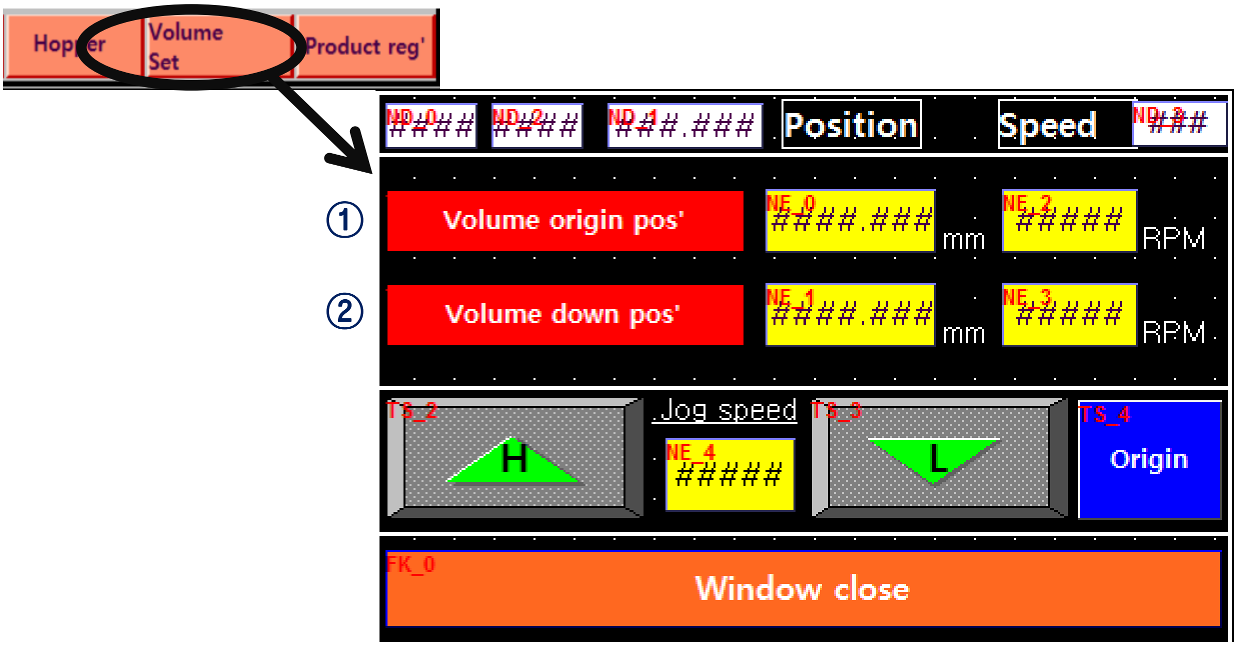

①
Disch' under move up delay
NE_0 ##.## Sec
②
Disch' picker delay after FWD
NE_1 ##.## Sec
③
Cleaning brush delay after down
NE_2 ##.## Sec
④
Hopper delay after end pos'
NE_3 ##.## Sec
FK_0
Window close

Menu	Description
(4) Discharge & Cleaning time setting	① Disch' under move up delay : Delay time of discharging picker after pounder up ② Disch' picker delay after FWD : Delay time of discharging picker after move forward ③ Cleaning brush delay after down : Delay time of brush before cleaning ④ Hoper delay after end pos' : Delay time of action hopper before next powder feeding.

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

2) Manual mode

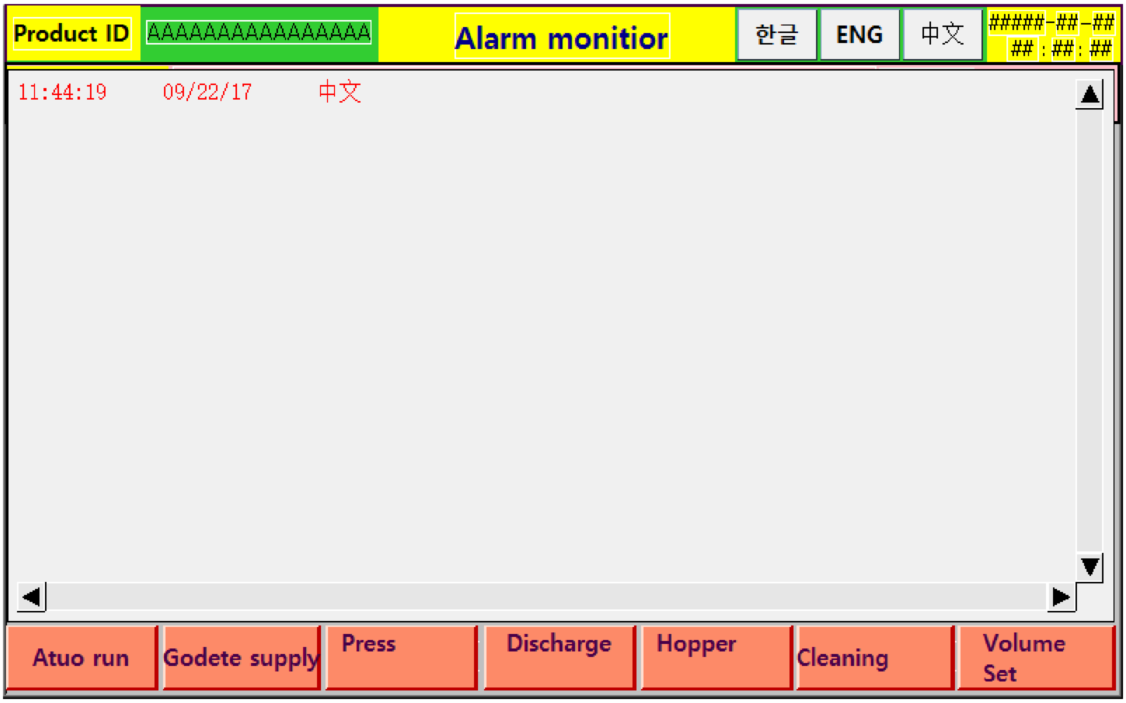

Hopper
Volume Set
Product reg'
ND_0 ####
ND_2 ####
ND_1 ###.###
Position
Speed
ND_3 ###
①
Volume origin pos'
NE_0 ####.###
mm
NE_2 #####
RPM
②
Volume down pos'
NE_1 ####.###
mm
NE_3 #####
RPM
TS_2
H
Jog speed
NE_4 #####
TS_3
L
TS_4
Origin
FK_0
Window close

Menu	Description
(4) Volume setting	① Volume origin pos' : Position value when ponder and turn table are at the same level. ② Volume down pos' : Pounder's lower position. (* Control this point when need to high or low volume.)

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

3) Alarm monitor


Product ID
Alarm monitor
한글
ENG
中文
#####-##-##
##:##:##
Atuo run
Godete supply
Press
Discharge
Hopper
Cleaning
Volume Set

Product ID: AAAAAAAAAAAAAAAAA

```
11:44:19      09/22/17      中文
```

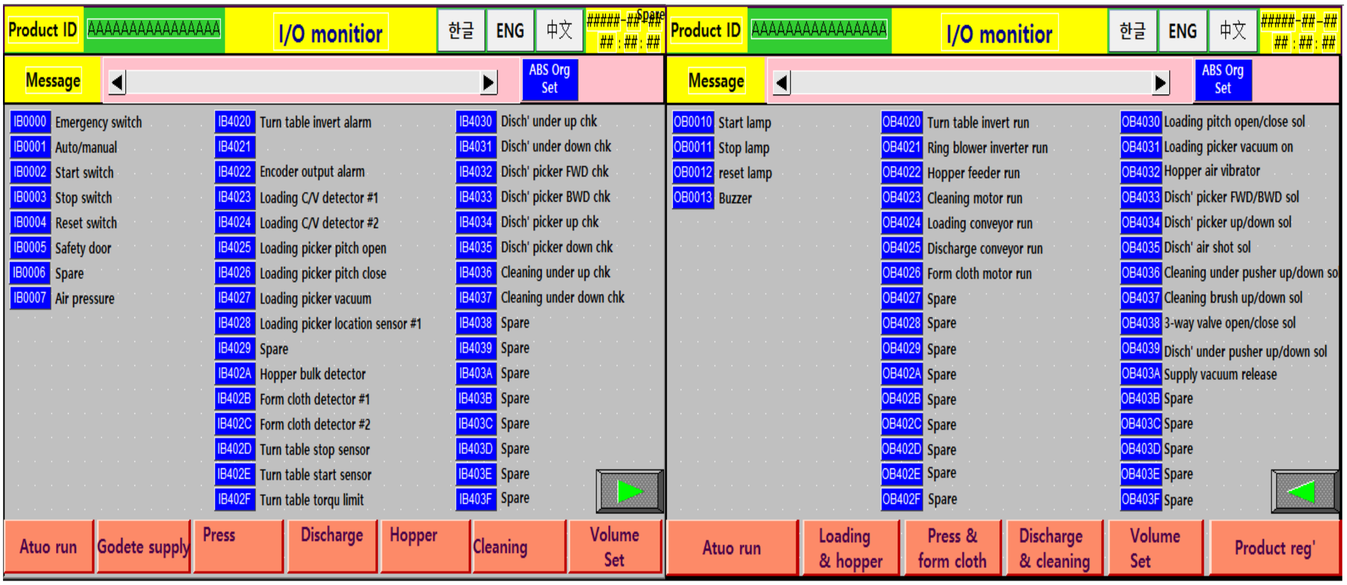
- Alarm list of abnormality during running

Menu	Description
Alarm list	Alarm list of main trouble & solution in order of time. Listed up while machine running & reset once machine turned off.

Do not use sharp tool for touch screen. Screen might get damage.

5. Touch screen

3) Input/Output monitor screen


Product ID
AAAAAAAAAAAAAAAA
I/O monitior
한글
ENG
中文
#####-##-##
## : ## : ##
Spare
Message
ABS Org Set
Atuo run
Godete supply
Press
Discharge
Hopper
Cleaning
Volume Set
Product ID
AAAAAAAAAAAAAAAA
I/O monitior
한글
ENG
中文
#####-##-##
## : ## : ##
Message
ABS Org Set
Atuo run
Loading & hopper
Press & form cloth
Discharge & cleaning
Volume Set
Product reg'

IB0000	Emergency switch	IB4020	Turn table invert alarm	IB4030	Disch' under up chk
IB0001	Auto/manual	IB4021		IB4031	Disch' under down chk
IB0002	Start switch	IB4022	Encoder output alarm	IB4032	Disch' picker FWD chk
IB0003	Stop switch	IB4023	Loading C/V detector #1	IB4033	Disch' picker BWD chk
IB0004	Reset switch	IB4024	Loading C/V detector #2	IB4034	Disch' picker up chk
IB0005	Safety door	IB4025	Loading picker pitch open	IB4035	Disch' picker down chk
IB0006	Spare	IB4026	Loading picker pitch close	IB4036	Cleaning under up chk
IB0007	Air pressure	IB4027	Loading picker vacuum	IB4037	Cleaning under down chk
		IB4028	Loading picker location sensor #1	IB4038	Spare
		IB4029	Spare	IB4039	Spare
		IB402A	Hopper bulk detector	IB403A	Spare
		IB402B	Form cloth detector #1	IB403B	Spare
		IB402C	Form cloth detector #2	IB403C	Spare
		IB402D	Turn table stop sensor	IB403D	Spare
		IB402E	Turn table start sensor	IB403E	Spare
		IB402F	Turn table torqu limit	IB403F	Spare

OB0010	Start lamp	OB4020	Turn table invert run	OB4030	Loading pitch open/close sol
OB0011	Stop lamp	OB4021	Ring blower inverter run	OB4031	Loading picker vacuum on
OB0012	reset lamp	OB4022	Hopper feeder run	OB4032	Hopper air vibrator
OB0013	Buzzer	OB4023	Cleaning motor run	OB4033	Disch' picker FWD/BWD sol
		OB4024	Loading conveyor run	OB4034	Disch' picker up/down sol
		OB4025	Discharge conveyor run	OB4035	Disch' air shot sol
		OB4026	Form cloth motor run	OB4036	Cleaning under pusher up/down so
		OB4027	Spare	OB4037	Cleaning brush up/down sol
		OB4028	Spare	OB4038	3-way valve open/close sol
		OB4029	Spare	OB4039	Disch' under pusher up/down sol
		OB402A	Spare	OB403A	Supply vacuum release
		OB402B	Spare	OB403B	Spare
		OB402C	Spare	OB403C	Spare
		OB402D	Spare	OB403D	Spare
		OB402E	Spare	OB403E	Spare
		OB402F	Spare	OB403F	Spare

- Check sensor on/off during machine operation.

Do not use sharp tool for touch screen. Screen might get damage.

6. Machine operate & turn off

1) Order of operation

*Machine : PSR-4800

1	Install machine where to run.
2	Supply electric power and check compressed air pressure. (*Proper compressed air 4~5bar)
3	Check valve closed.
4	Turn on power of OP BOX.
5	If [STOP] in OP BOX is blinking, cancel the abnormality by [RESET].
6	Change the mode from [MANUAL] to [AUTO].
7	If [START] is blinking, press [START] when operators are ready.

2) Order for turning off

1	Press <STOP> when production is over.
2	Clean the machine inside & outside after machine stops. (* Operator has to change mode from auto mode to manual mode.)
3	Turn off main power and disconnect compressed air.

⚠ Do not use sharp tool for touch screen. Screen might get damage.

7. Machine malfunction

1) Reset of machine

Machine will automatically stop with alarm sound and alarm screen will pop-up if alarm occurs during operation.

① DO NOT disregard error message from machine & solve error by simple labor

② Please switch into manual mode and beware of injury from unexpected situation.

③ Check alarm contents and press reset button after solve problem.

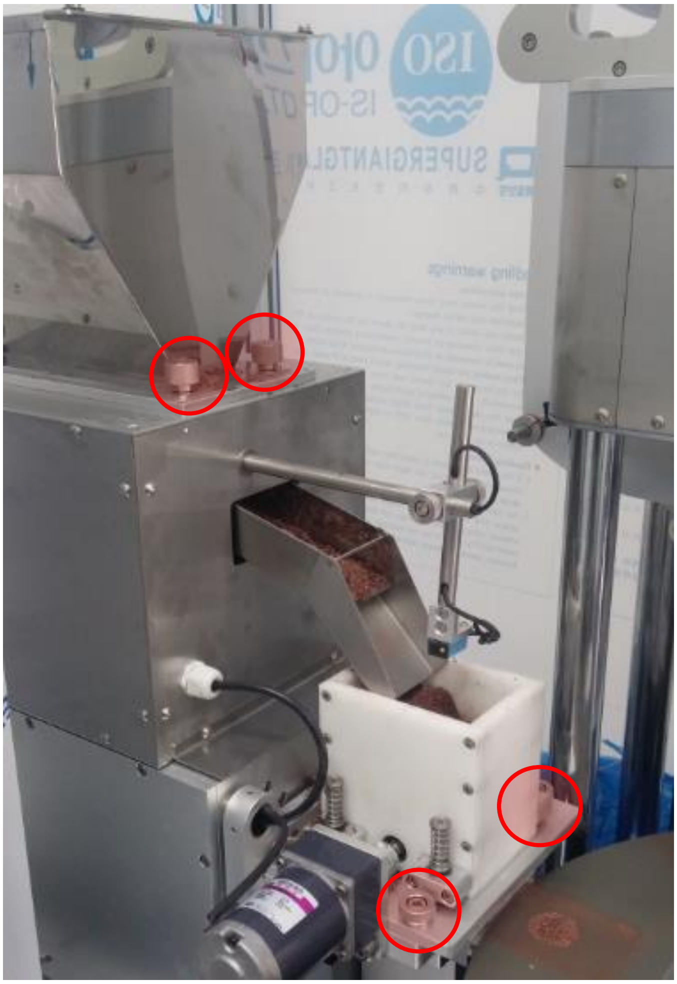
④ Contact LEIDEX if problem still remains.

2) Machine maintenance

Period	Measure
Spot check	- Cleaning In-conveyor - Cleaning turn table - Cleaning press part - Cleaning discharging unit - Cleaning Dust dish under press cloth
Everyday	- Checking powder feeding of action hopper to servo - Checking In-conveyor sensor working - Checking suction in discharging unit
Week	- Cleaning vacuum hose - Cleaning 3-WAY V/V of discharging part - Cleaning dust dish in discharging unit
Month	- Cleaning blower

8. Machine Cleaning

1) Hopper cleaning



1	Dismantle big hopper & action hopper from main body by loosing the bolt
2	Wipe out each hopper inside & outside with clean cloth & alcohol.

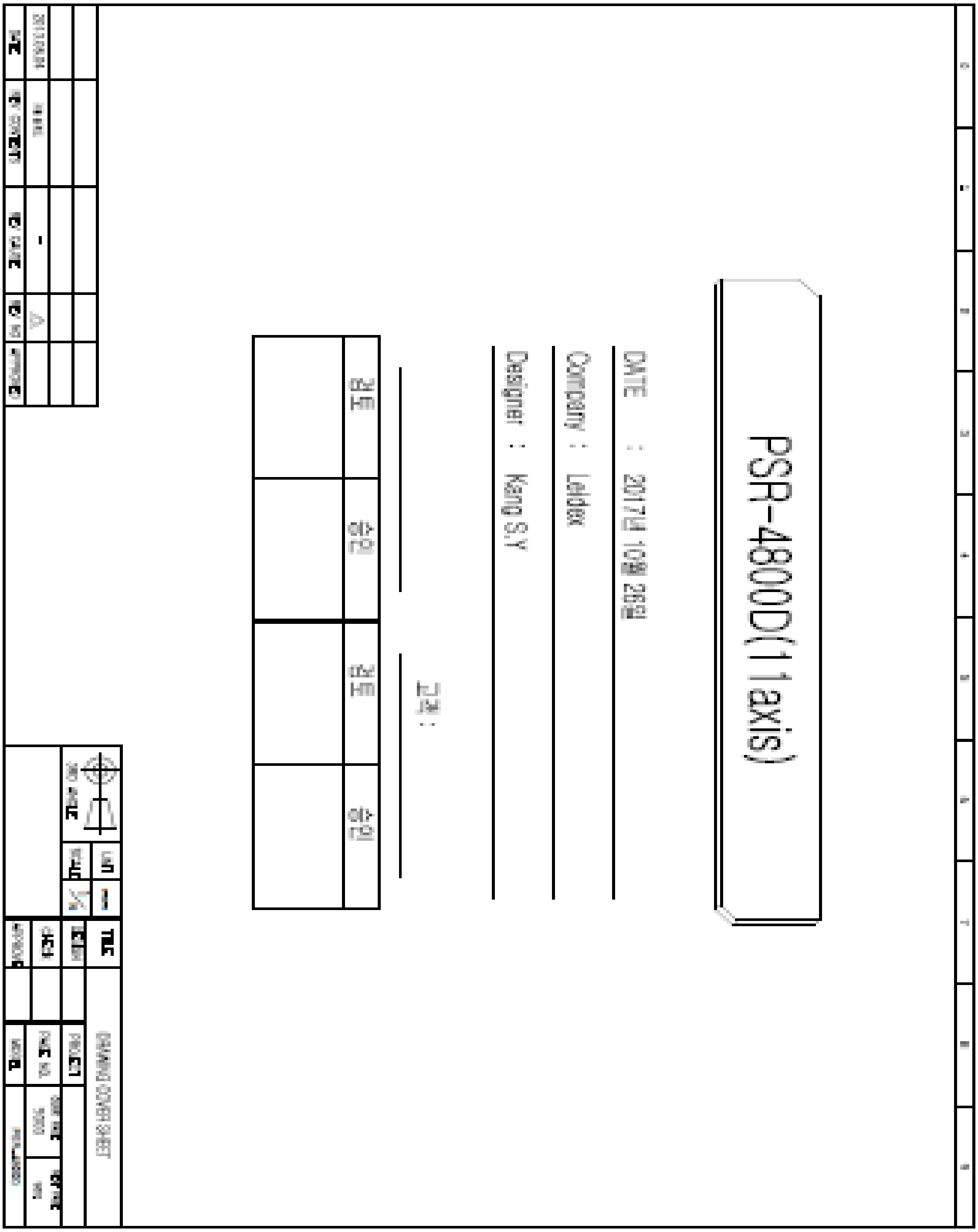
9. Tool box list

Model.		PSR-4800		
No	Name	Size	Count	Maker
1	Tool BOX	Jeongkwang 1	1	Jeongkwang
2	Wrenche SET	TLS-9N	1	EIGHT
3	Spanner	10 ”	1	Seshin
4	Driver	610×2×150(+)	1	CHAMPION
5	Spare SET	610×2×150(-)	1	CHAMPION
6	Scisso	190 ㎜	1	Seshin

9. Change part list

No	Name	Count	Remark
1	Turn table	1 ea	
2	Punch	1 ea	
3	Pounder	1 set	Pact 8 ea, shadow 32ea
4	Aluminum pan guide	1 set	
5	Vacuum pad	1 set	

11. Circuit



PSR-4800D(11axis)

DATE : 2017년 10월 26일

Company : Leidex

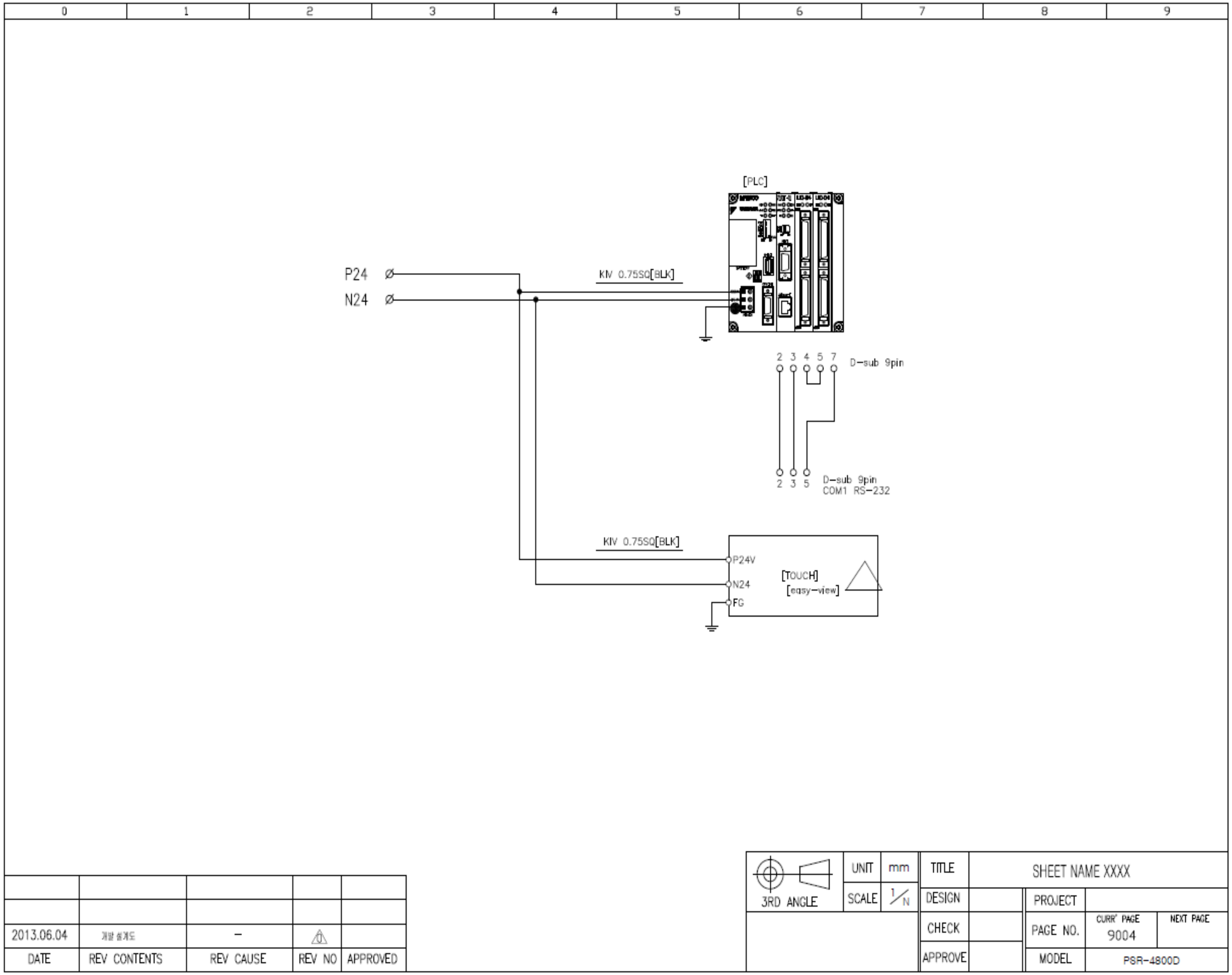
Designer : Kang S.Y

고객 :

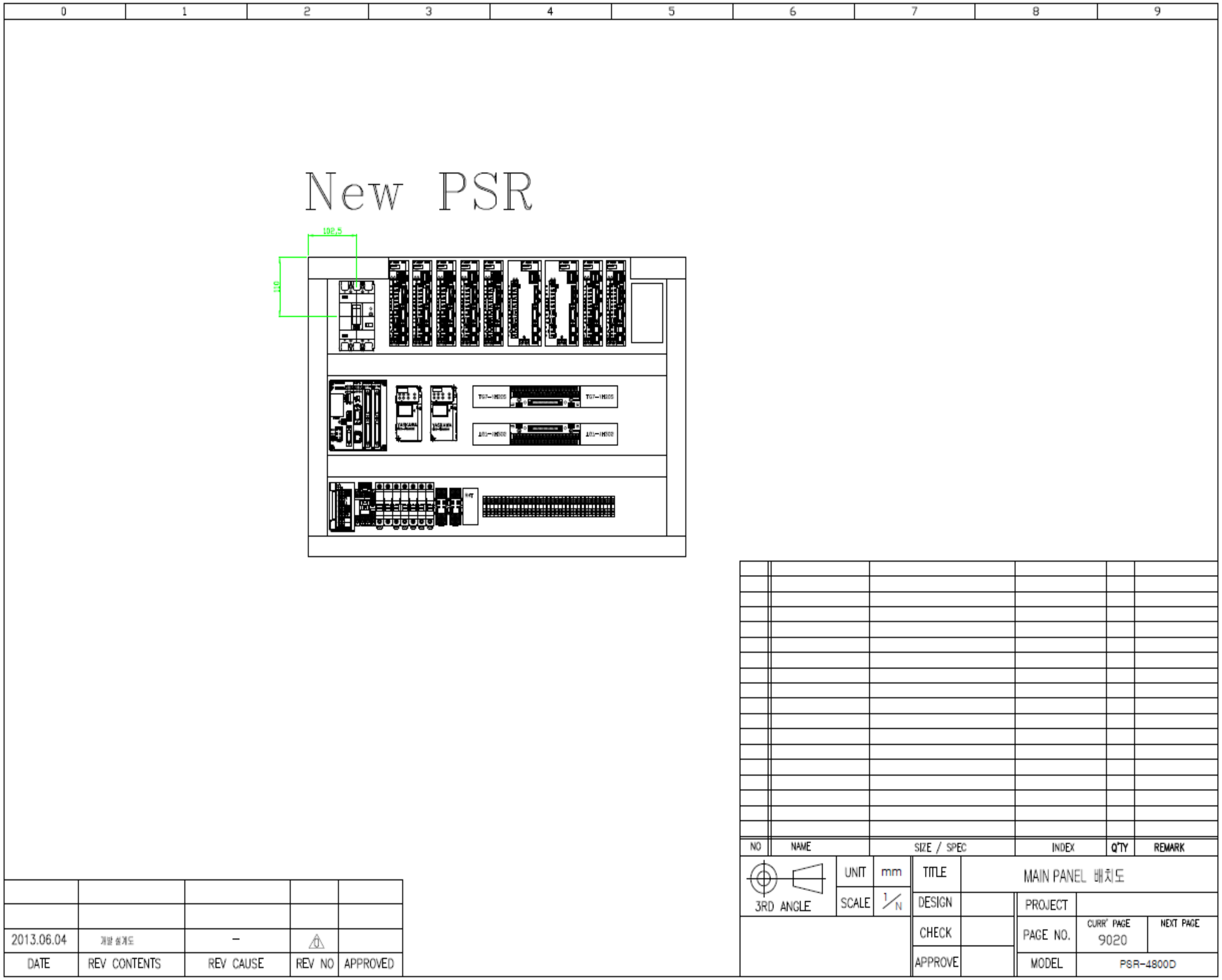
검토	승인	검토	승인

TITLE
DRAWING COVER SHEET
UNIT
SCALE
3RD ANGLE
DESIGN
CHECK
APPROVED
PROJECT
PAGE NO.
MODEL
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED

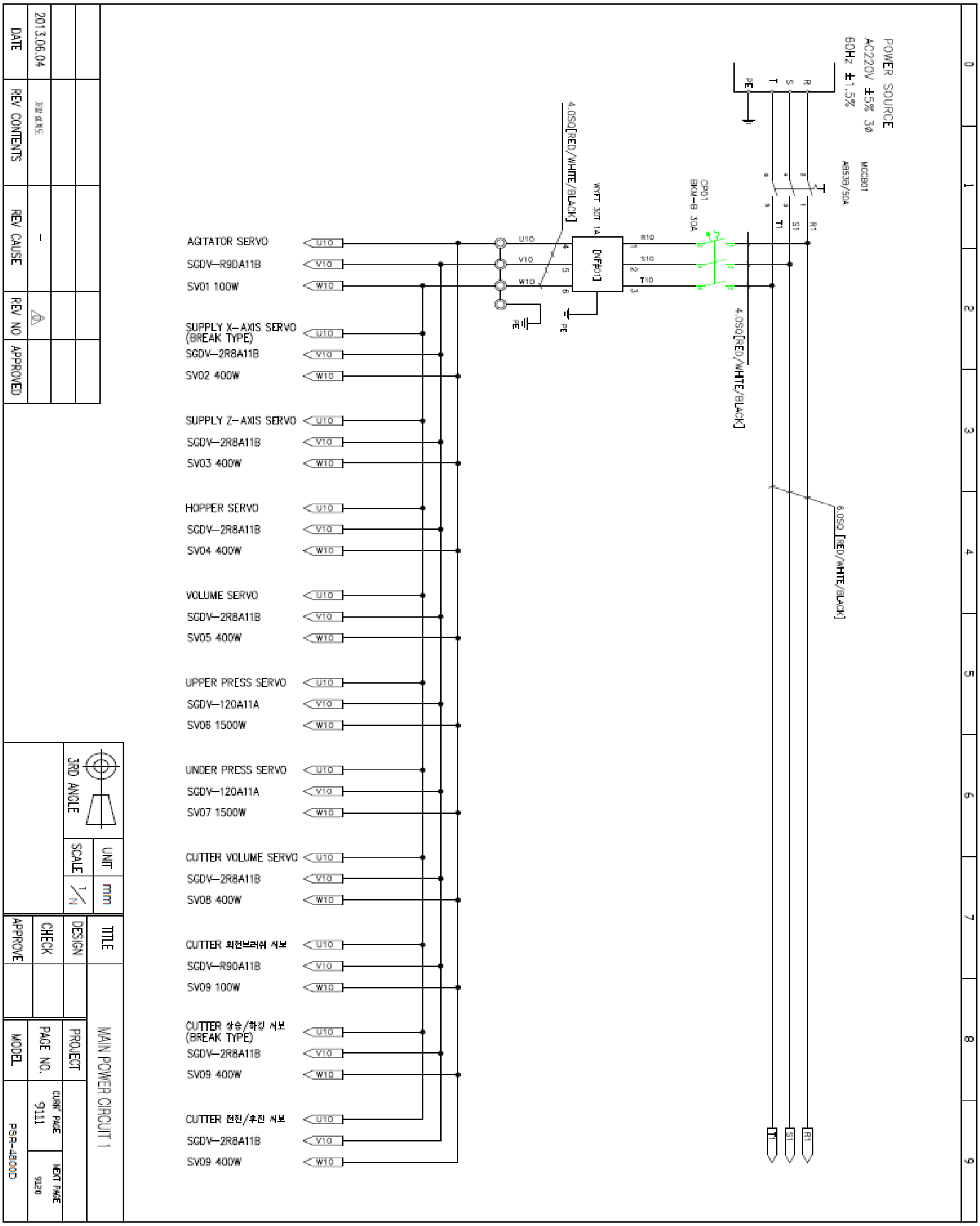
11. Circuit


0
1
2
3
4
5
6
7
8
9
[PLC]
P24
N24
KIV 0.75SQ[BLK]
2 3 4 5 7
D-sub 9pin
2 3 5
D-sub 9pin
COM1 RS-232
KIV 0.75SQ[BLK]
P24V
N24
FG
[TOUCH]
[easy-view]
2013.06.04
개발 설계도
–
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SHEET NAME XXXX
DESIGN
PROJECT
CHECK
PAGE NO.
CURR' PAGE
9004
NEXT PAGE
APPROVE
MODEL
PSR-4800D

11. Circuit

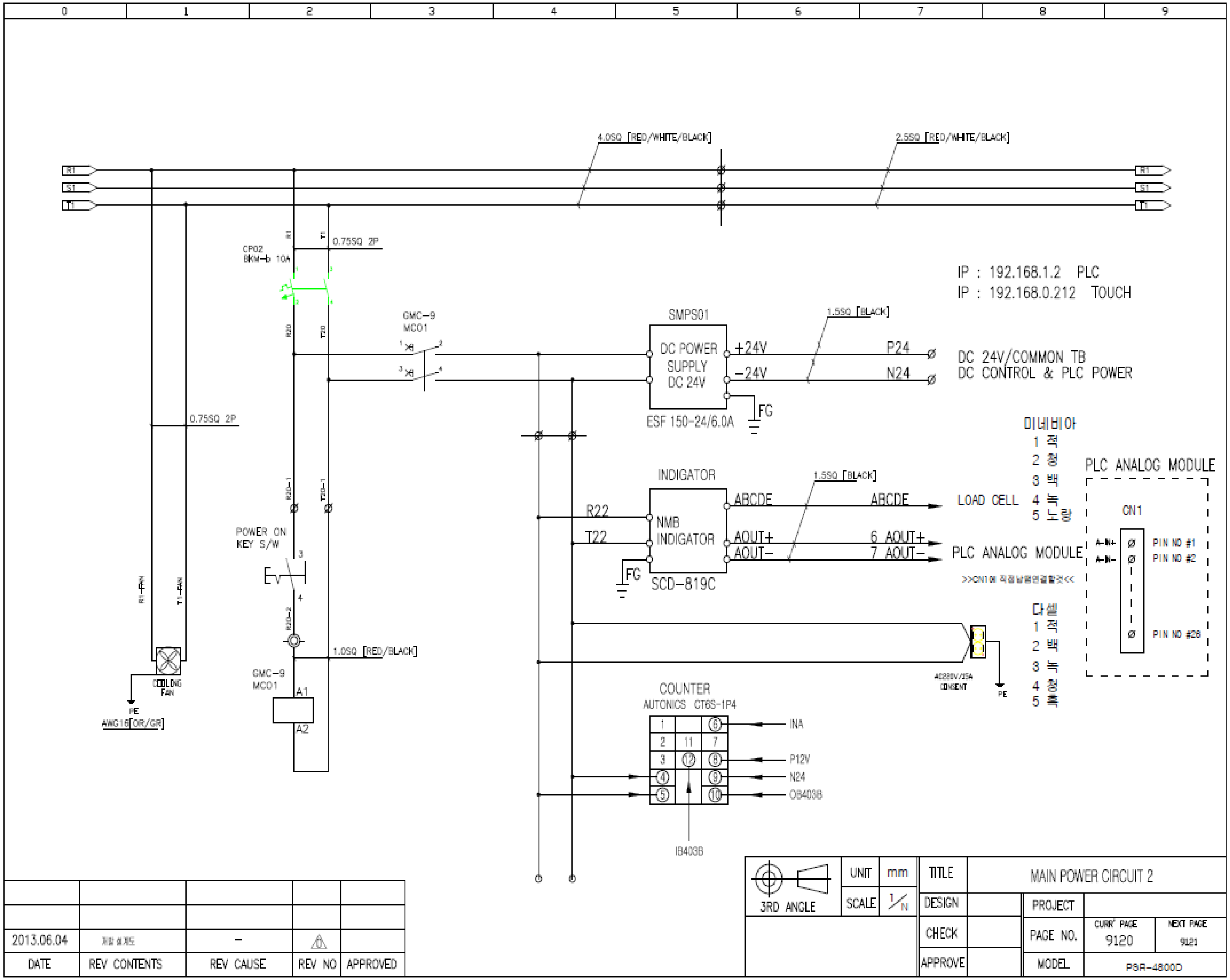

0
1
2
3
4
5
6
7
8
9
New PSR
102,5
110
TG7-1H20S
TG7-1H20S
TG7-1H20S
TG7-1H20S
YASKAWA
YASKAWA
SMT
NO
NAME
SIZE / SPEC
INDEX
Q'TY
REMARK
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
MAIN PANEL 배치도
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9020
NEXT PAGE
MODEL
PSR-4800D
2013.06.04
개발 설계도
–
⚠
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED

11. Circuit

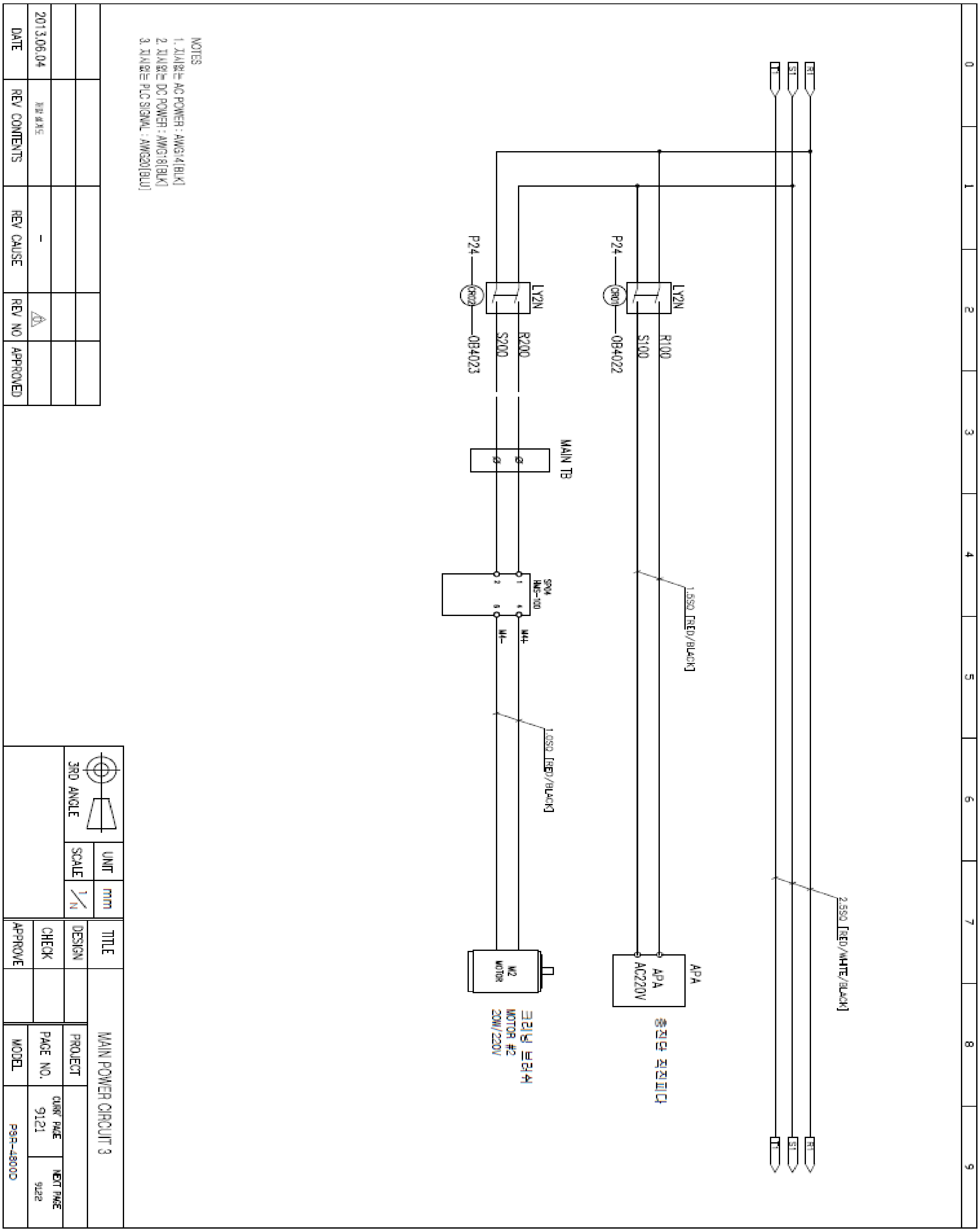


POWER SOURCE
AC220V ±5% 3Ø
60Hz ±1.5%
R
S
T
PE
MCCB01
AB53B/50A
R1
S1
T1
CP01
BKM-B 30A
R10
S10
T10
[NF#01]
WYT 30T 1A
U10
V10
W10
PE
4.0SQ[RED/WHITE/BLACK]
4.0SQ[RED/WHITE/BLACK]
6.0SQ [RED/WHITE/BLACK]
AGITATOR SERVO
SGDV-R90A11B
SV01 100W
SUPPLY X-AXIS SERVO
(BREAK TYPE)
SGDV-2R8A11B
SV02 400W
SUPPLY Z-AXIS SERVO
SGDV-2R8A11B
SV03 400W
HOPPER SERVO
SGDV-2R8A11B
SV04 400W
VOLUME SERVO
SGDV-2R8A11B
SV05 400W
UPPER PRESS SERVO
SGDV-120A11A
SV06 1500W
UNDER PRESS SERVO
SGDV-120A11A
SV07 1500W
CUTTER VOLUME SERVO
SGDV-2R8A11B
SV08 400W
CUTTER 회전브러쉬 서보
SGDV-R90A11B
SV09 100W
CUTTER 상승/하강 서보
(BREAK TYPE)
SGDV-2R8A11B
SV09 400W
CUTTER 전진/후진 서보
SGDV-2R8A11B
SV09 400W
U10
V10
W10
R1
S1
T1
0
1
2
3
4
5
6
7
8
9
DATE
2013.06.04
REV CONTENTS
REV CAUSE
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
MAIN POWER CIRCUIT 1
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR PAGE
9111
NEXT PAGE
9120
MODEL
PBR-4800D

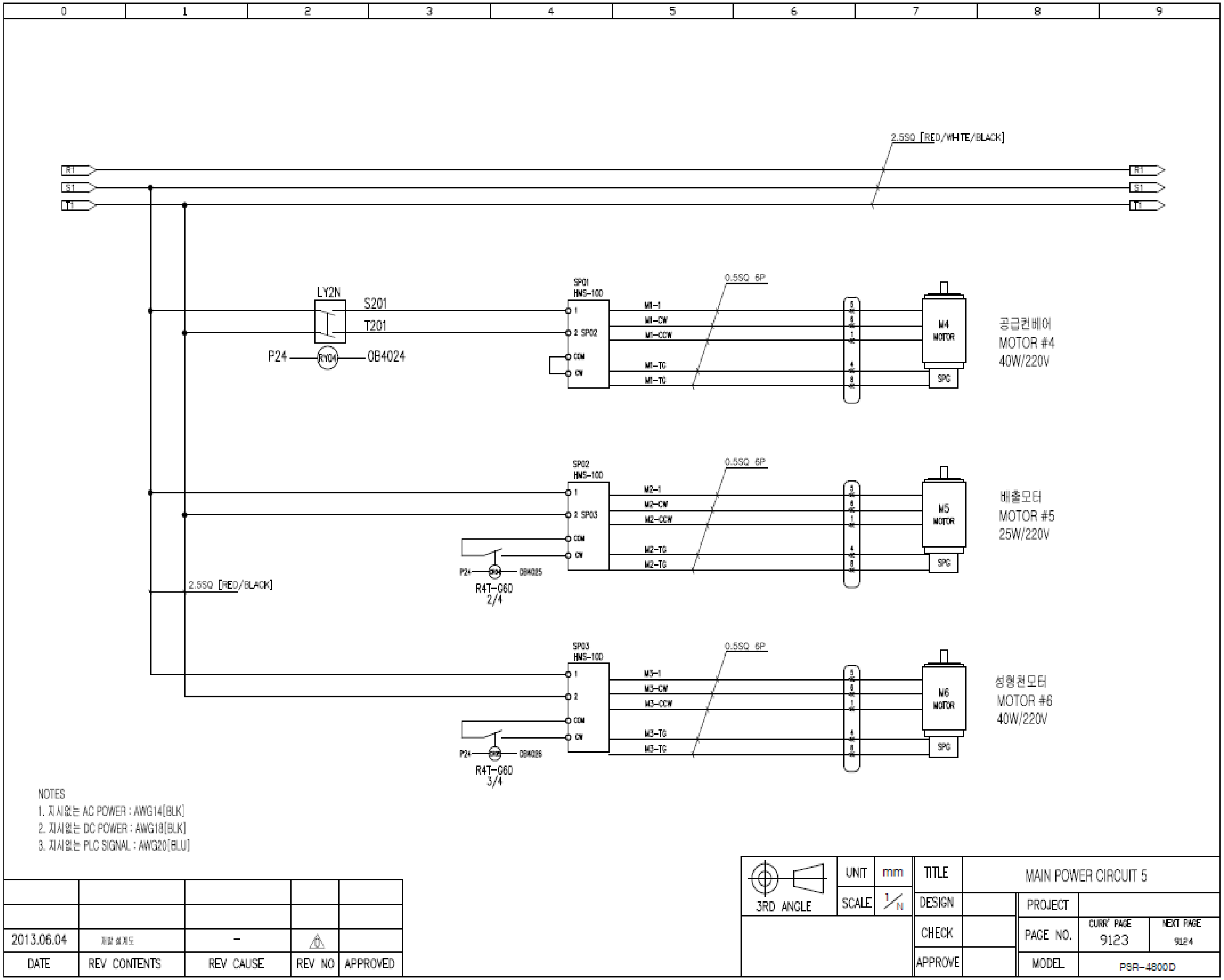
11. Circuit


0
1
2
3
4
5
6
7
8
9
R1
S1
T1
4.0SQ [RED/WHITE/BLACK]
2.5SQ [RED/WHITE/BLACK]
0.75SQ 2P
CP02
BKM-b 10A
R20
T20
GMC-9
MC01
SMPS01
DC POWER SUPPLY DC 24V
+24V
-24V
P24
N24
FG
ESF 150-24/6.0A
1.5SQ [BLACK]
IP : 192.168.1.2 PLC
IP : 192.168.0.212 TOUCH
DC 24V/COMMON TB
DC CONTROL & PLC POWER
미네비아
1 적
2 청
3 백
4 녹
5 노랑
PLC ANALOG MODULE
INDIGATOR
NMB INDIGATOR
SCD-819C
R22
T22
ABCDE
AOUT+
AOUT-
6 AOUT+
7 AOUT-
LOAD CELL
PLC ANALOG MODULE
>>CN1에 직접납땜연결할것<<
CN1
A-IN+
A-IN-
PIN NO #1
PIN NO #2
PIN NO #26
다셀
1 적
2 백
3 녹
4 청
5 흑
AC220V/15A
CONSENT
PE
R20-1
T20-1
POWER ON
KEY S/W
R20-2
1.0SQ [RED/BLACK]
A1
A2
R1-FAN
T1-FAN
COOLING FAN
AWG16[OR/GR]
COUNTER
AUTONICS CT6S-1P4
INA
P12V
N24
OB403B
IB403B
2013.06.04
개발 설계도
-
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
MAIN POWER CIRCUIT 2
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9120
NEXT PAGE
9121
MODEL
PSR-4800D

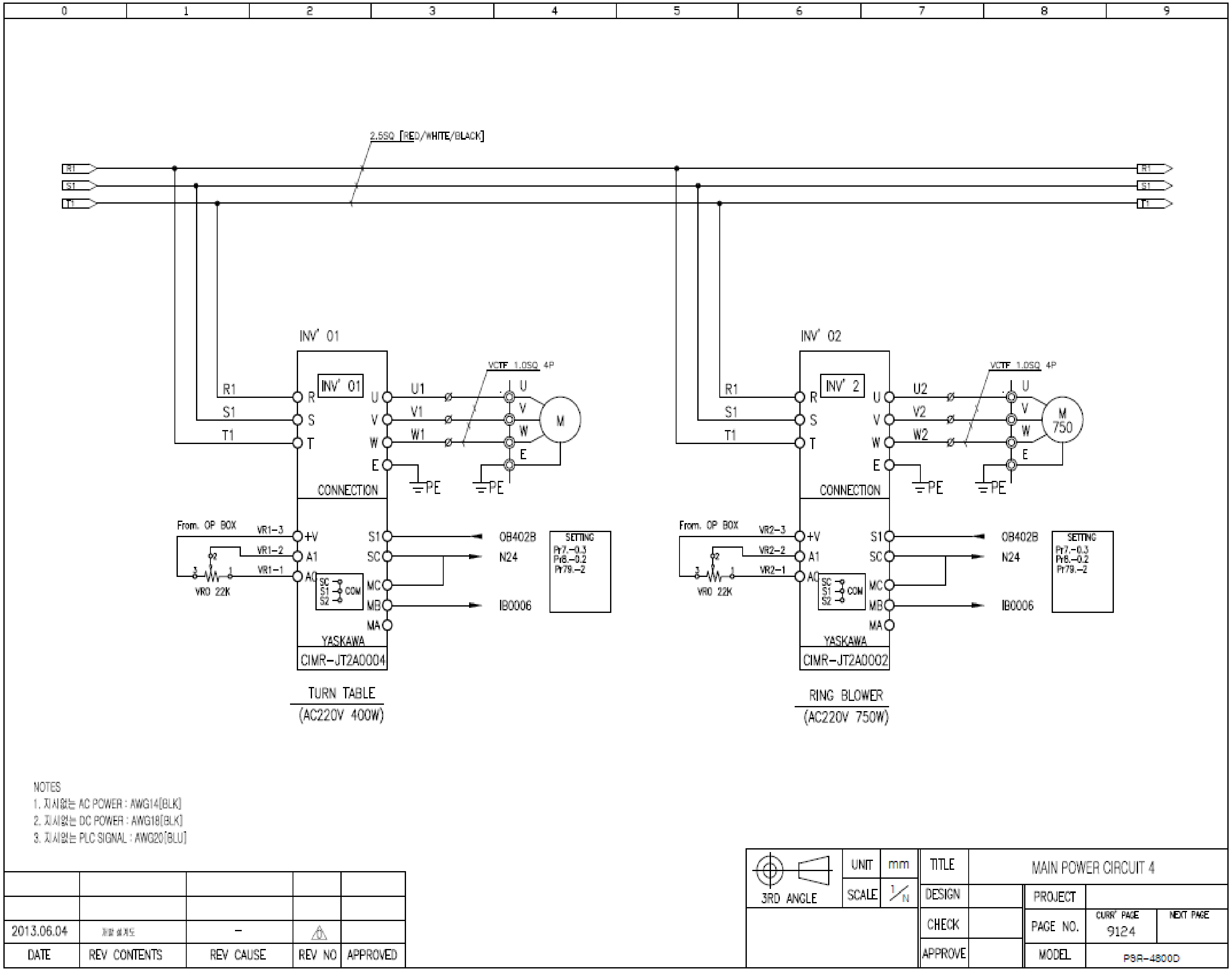
11. Circuit


0
1
2
3
4
5
6
7
8
9
R1
S1
T1
P24
CR01
OB4022
LY2N
R100
S100
P24
CR02
OB4023
LY2N
R200
S200
MAIN TB
SPO4
NMS-100
M+
M-
1.5SQ [RED/BLACK]
1.0SQ [RED/BLACK]
2.5SQ [RED/WHITE/BLACK]
APA
APA
AC220V
흡착 직진피더
M2
MOTOR
크리너 브러쉬
MOTOR #2
20W/220V
NOTES
1. 지시없는 AC POWER : AWG14[BLK]
2. 지시없는 DC POWER : AWG18[BLK]
3. 지시없는 PLC SIGNAL : AWG20[BLU]
DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
MAIN POWER CIRCUIT 3
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9121
NEXT PAGE
9122
MODEL
PSR-4800D

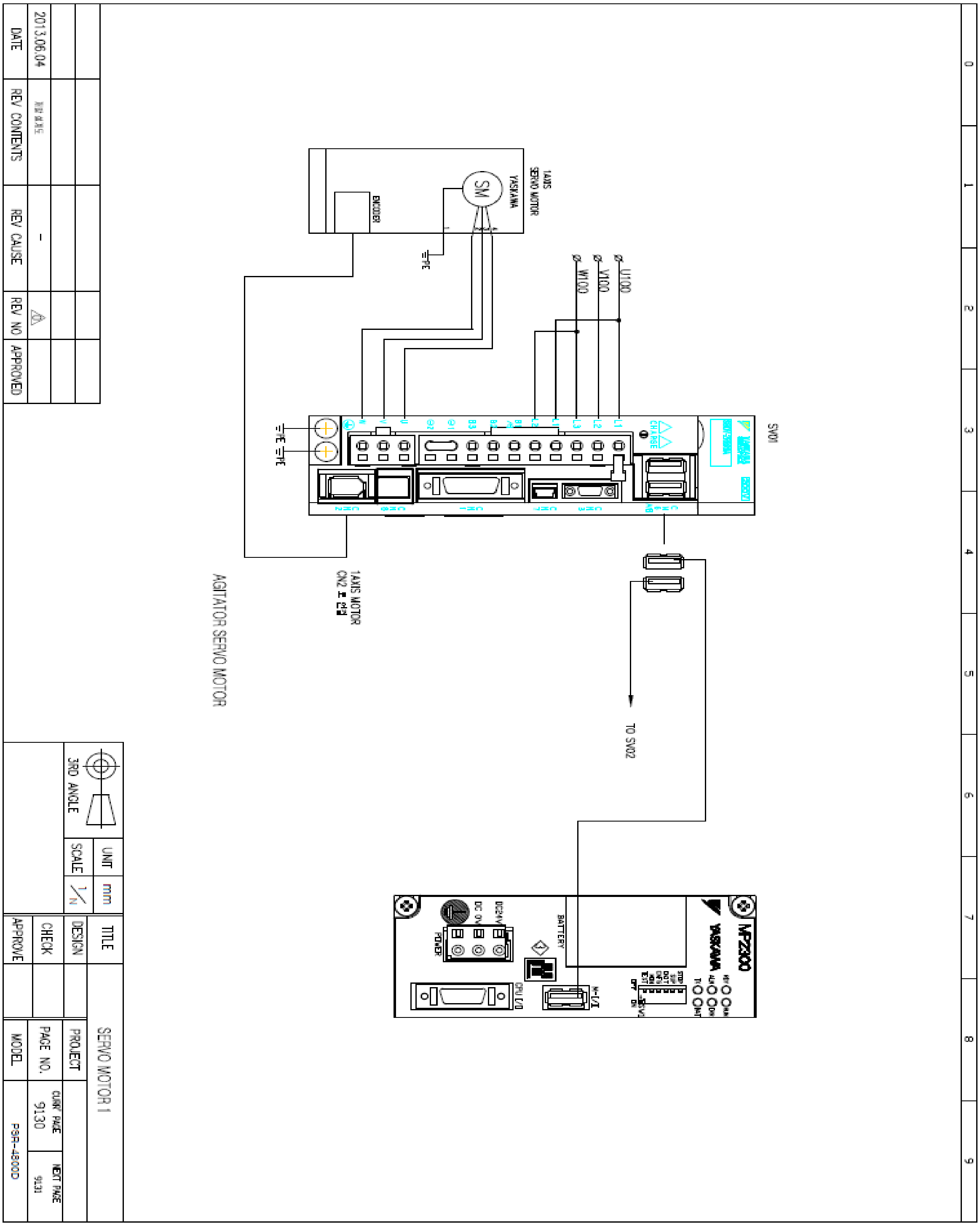
11. Circuit


0
1
2
3
4
5
6
7
8
9
R1
S1
T1
2.5SQ [RED/WHITE/BLACK]
LY2N
S201
T201
P24
RY04
OB4024
SP01
HMS-100
1
2 SP02
COM
CW
M1-1
M1-CW
M1-CCW
M1-TG
M1-TG
0.5SQ 6P
5
6
1
4
8
M4
MOTOR
SPG
공급컨베어
MOTOR #4
40W/220V
SP02
HMS-100
1
2 SP03
COM
CW
P24
OB4025
R4T-G60
2/4
M2-1
M2-CW
M2-CCW
M2-TG
M2-TG
0.5SQ 6P
M5
MOTOR
SPG
배출모터
MOTOR #5
25W/220V
2.5SQ [RED/BLACK]
SP03
HMS-100
1
2
COM
CW
P24
OB4026
R4T-G60
3/4
M3-1
M3-CW
M3-CCW
M3-TG
M3-TG
0.5SQ 6P
M6
MOTOR
SPG
성형천모터
MOTOR #6
40W/220V
NOTES
1. 지시없는 AC POWER : AWG14[BLK]
2. 지시없는 DC POWER : AWG18[BLK]
3. 지시없는 PLC SIGNAL : AWG20[BLU]
2013.06.04
-
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
MAIN POWER CIRCUIT 5
DESIGN
PROJECT
CHECK
PAGE NO.
CURR' PAGE
9123
NEXT PAGE
9124
APPROVE
MODEL
PSR-4800D

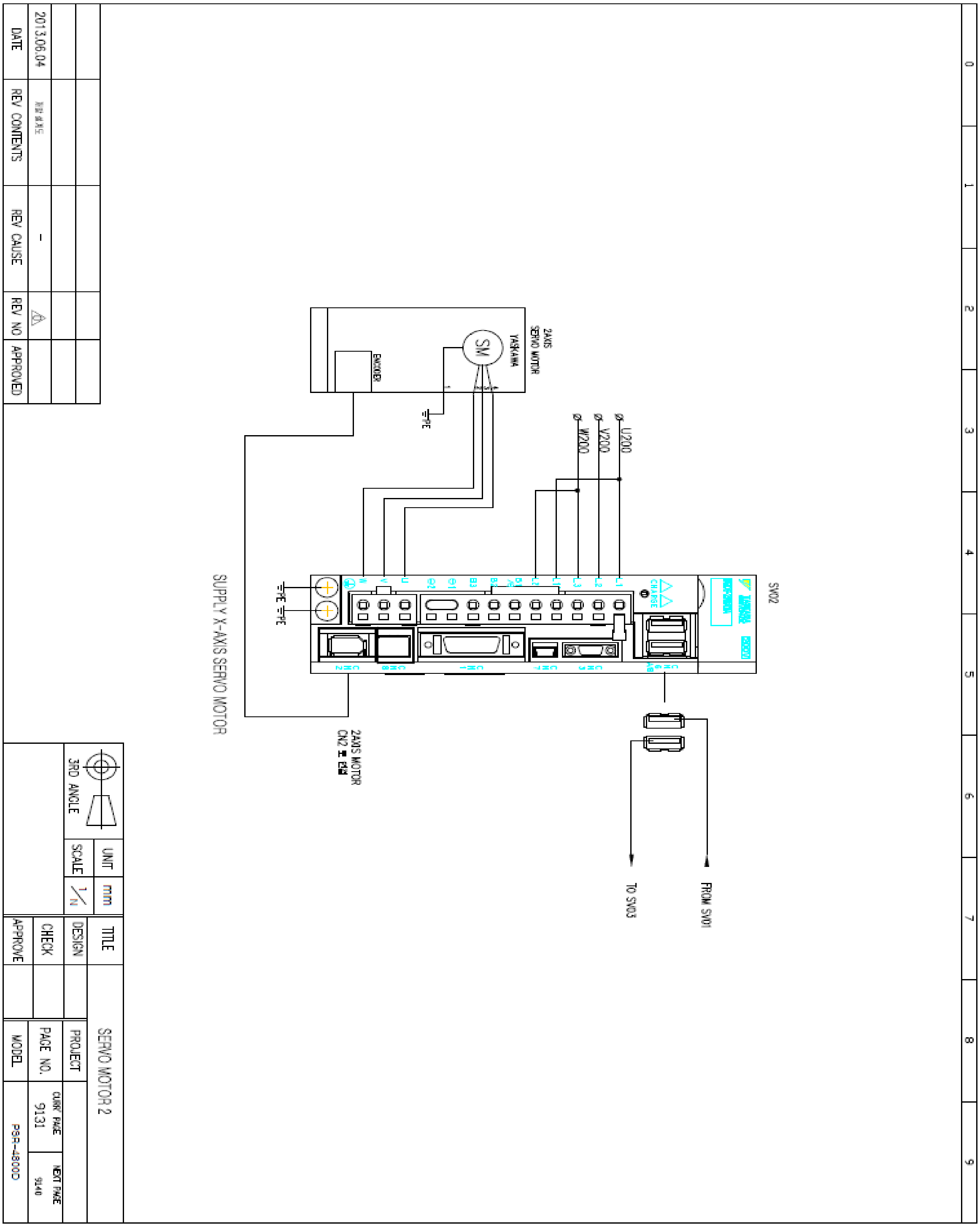
11. Circuit


0
1
2
3
4
5
6
7
8
9
2.5SQ [RED/WHITE/BLACK]
R1
S1
T1
INV' 01
INV' 01
R
S
T
U
V
W
E
U1
V1
W1
VCTF 1.0SQ 4P
M
PE
PE
CONNECTION
From. OP BOX
VR1-3
VR1-2
VR1-1
VR0 22K
+V
A1
AC
SC
S1
S2
COM
S1
SC
MC
MB
MA
OB402B
N24
IB0006
SETTING
Pr7.-0.3
Pr8.-0.2
Pr79.-2
YASKAWA
CIMR-JT2A0004
TURN TABLE
(AC220V 400W)
INV' 02
INV' 2
U2
V2
W2
M
750
From. OP BOX
VR2-3
VR2-2
VR2-1
YASKAWA
CIMR-JT2A0002
RING BLOWER
(AC220V 750W)
NOTES
1. 지시없는 AC POWER : AWG14[BLK]
2. 지시없는 DC POWER : AWG18[BLK]
3. 지시없는 PLC SIGNAL : AWG20[BLU]
2013.06.04
개발 설계도
-
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
MAIN POWER CIRCUIT 4
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9124
NEXT PAGE
MODEL
PSR-4800D

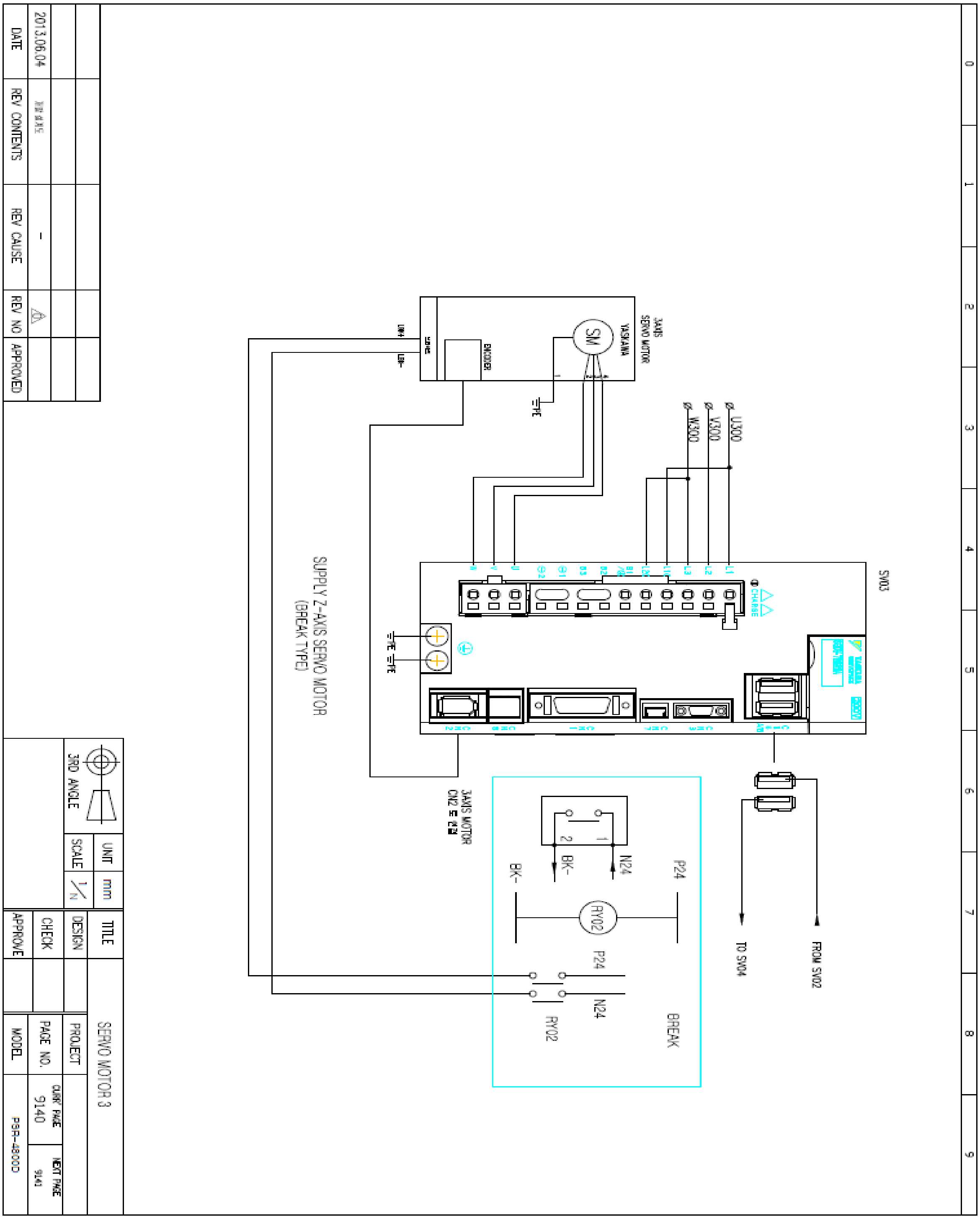
11. Circuit


1AXIS SERVO MOTOR
YASKAWA
SM
ENCODER
PE
U100
V100
W100
SV01
CHARGE
1AXIS MOTOR CN2
AGITATOR SERVO MOTOR
TO SV02
MP2300
YASKAWA
BATTERY
DC24V
DC 0V
POWER
CPU I/O
M-I/II
DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 1
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR PAGE
9130
NEXT PAGE
9131
MODEL
PSR-4800D

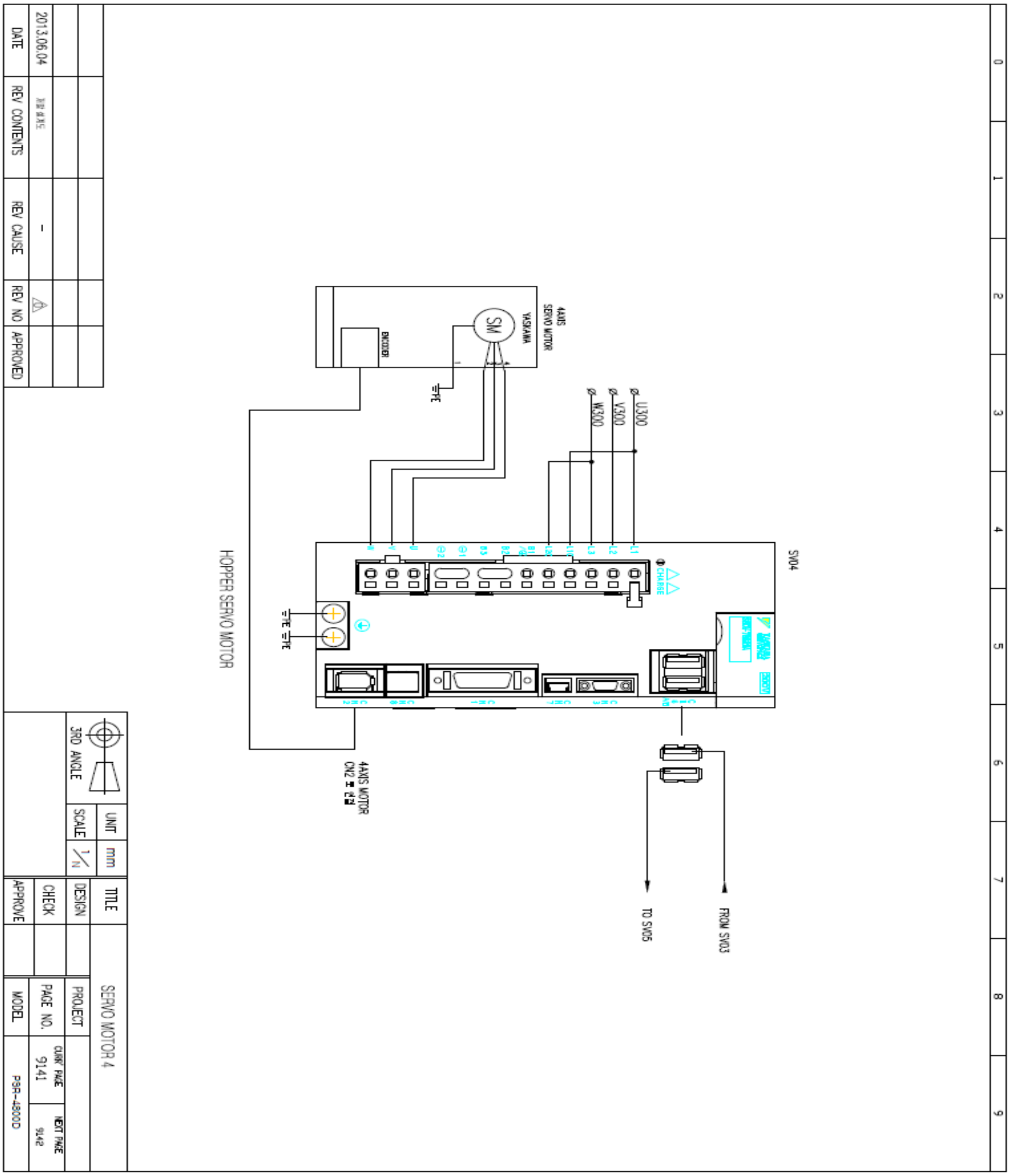
11. Circuit


DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
2AXIS SERVO MOTOR
YASKAWA
SM
ENCODER
PE
U200
V200
W200
SV02
CHARGE
SUPPLY X-AXIS SERVO MOTOR
2AXIS MOTOR CN2
TO SV03
FROM SV01
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 2
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9131
NEXT PAGE
9140
MODEL
PSR-4800D
0
1
2
3
4
5
6
7
8
9

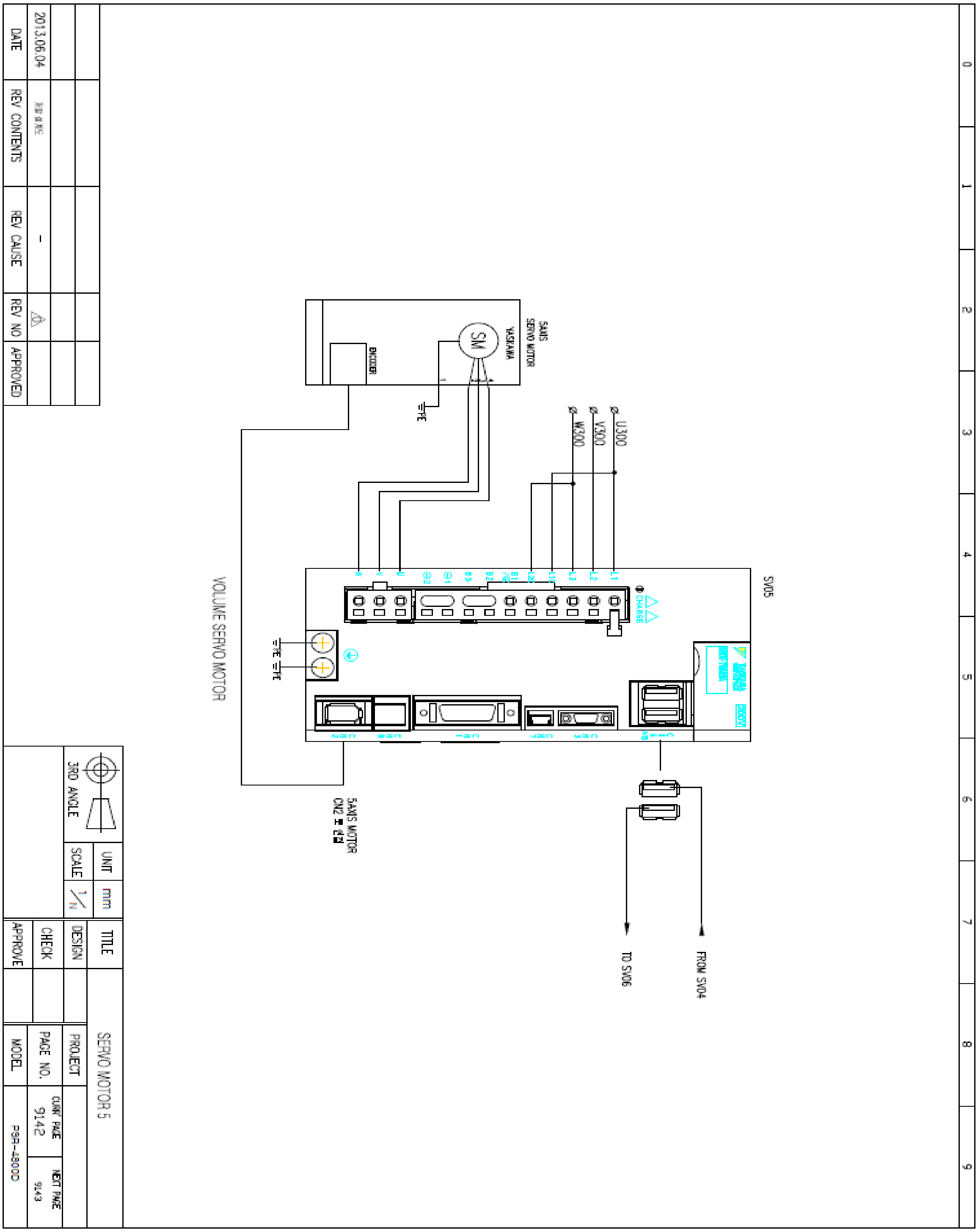
11. Circuit


DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
0
1
2
3
4
5
6
7
8
9
3AXIS SERVO MOTOR
YASKAWA
SM
ENCODER
BK+
BK-
FE
U300
V300
W300
SV03
W
V
U
⊖2
⊕1
B3
B2
B1/⊕
L2C
L1C
L3
L2
L1
CHARGE
FE
FE
CN2
CN8
CN1
CN7
CN3
CN6A
SUPPLY Z-AXIS SERVO MOTOR
(BREAK TYPE)
3AXIS MOTOR CN2
FROM SV02
TO SV04
P24
N24
BK-
1
2
BK-
RY02
P24
N24
RY02
BREAK
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 3
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9140
NEXT PAGE
9141
MODEL
PSR-4800D

11. Circuit

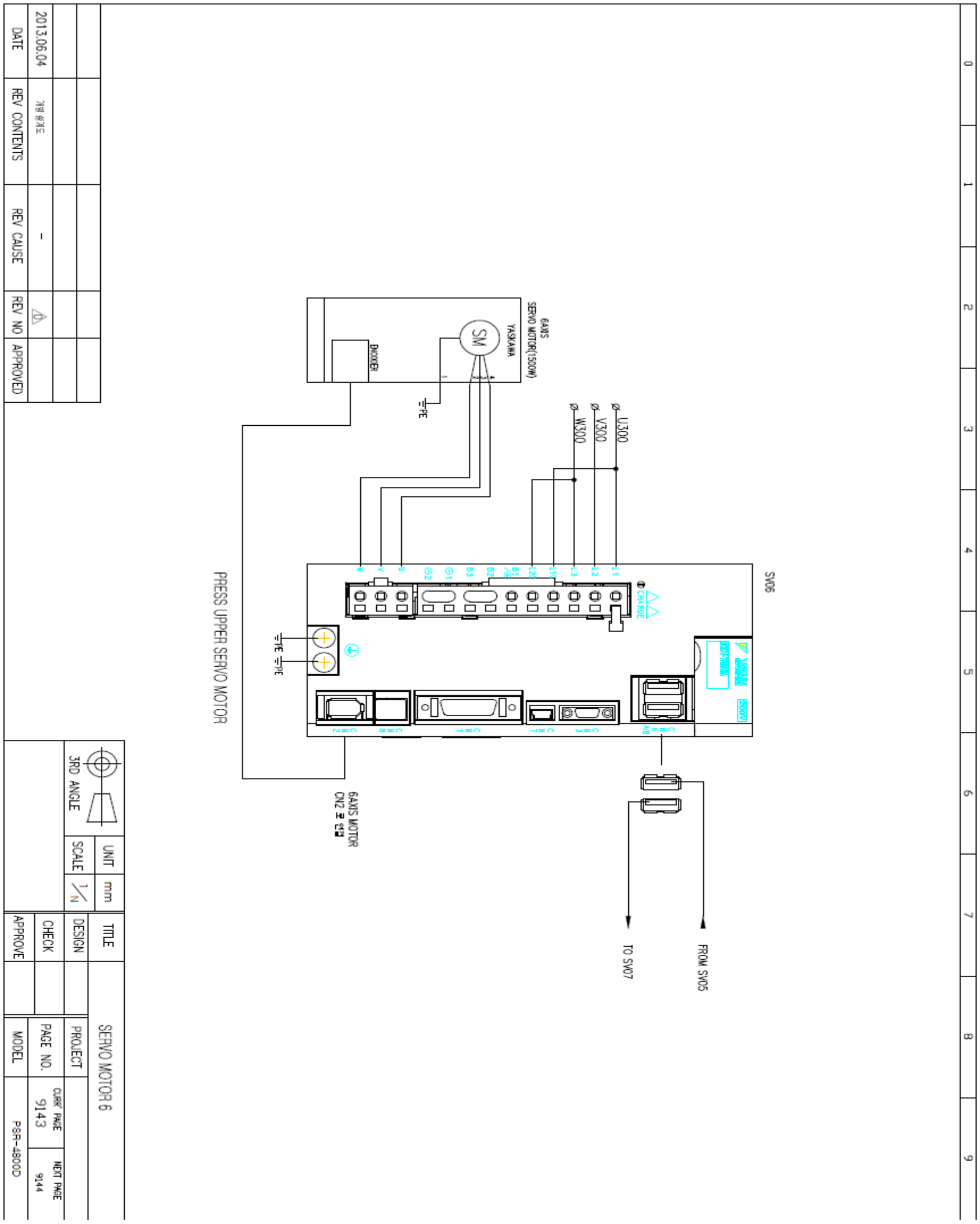

DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
4AXIS SERVO MOTOR YASKAWA
SM
ENCODER
FE
Ø U300
Ø V300
Ø W300
SV04
L1
L2
L3
L1C
L2C
B1/⊕
B2
B3
⊖1
⊖2
U
V
W
CHARGE
CN1
CN2
CN3
CN7
CN8
HOPPER SERVO MOTOR
4AXIS MOTOR CN2 로 연결
FROM SV03
TO SV05
0
1
2
3
4
5
6
7
8
9
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 4
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9141
NEXT PAGE
9142
MODEL
PSR-4800D

11. Circuit

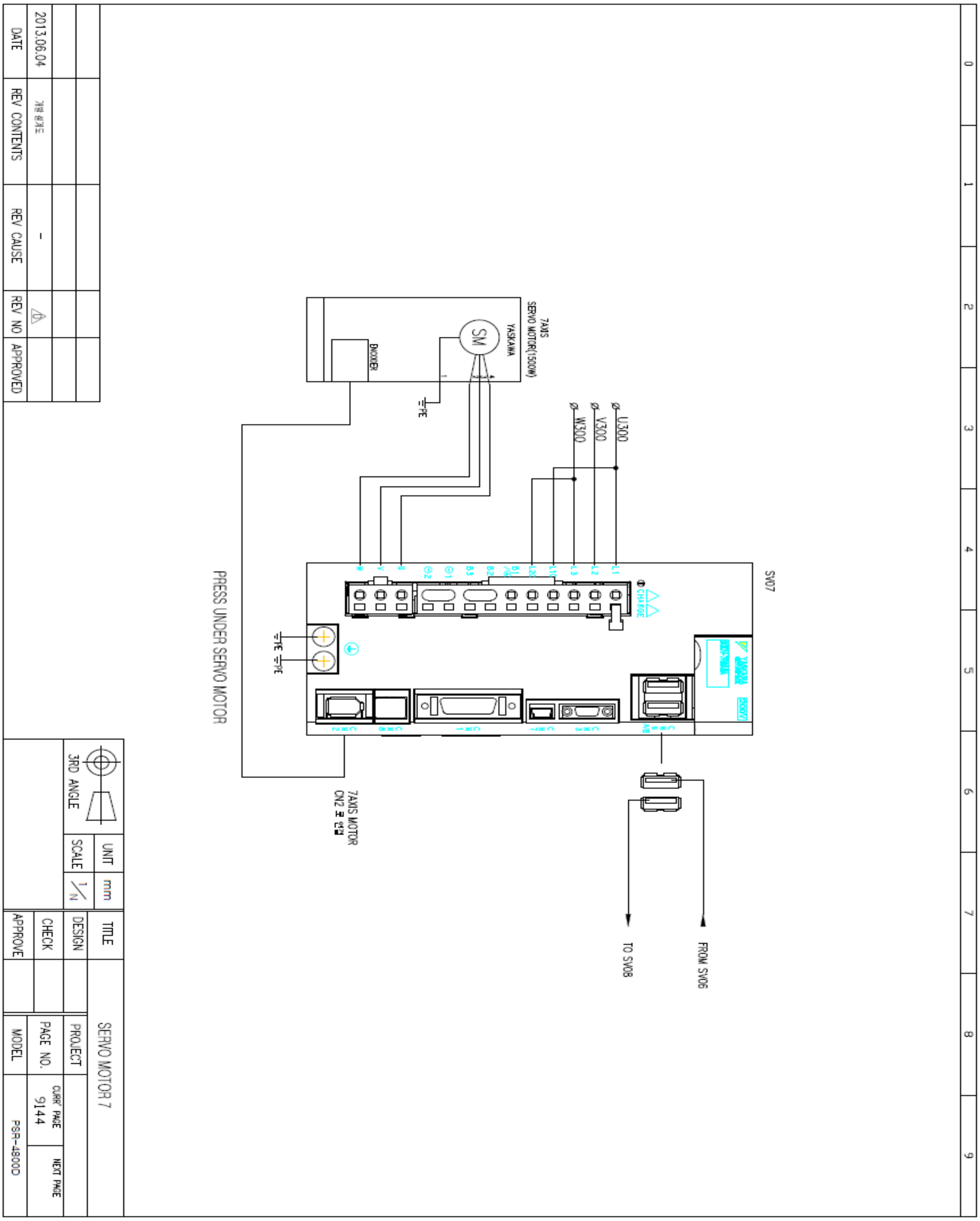


0
1
2
3
4
5
6
7
8
9
5AXIS SERVO MOTOR
YASKAWA
SM
ENCODER
PE
U300
V300
W300
SV05
CHARGE
VOLUME SERVO MOTOR
5AXIS MOTOR CN2
TO SV06
FROM SV04
DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 5
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR PAGE
9142
NEXT PAGE
9143
MODEL
PBR-4800D

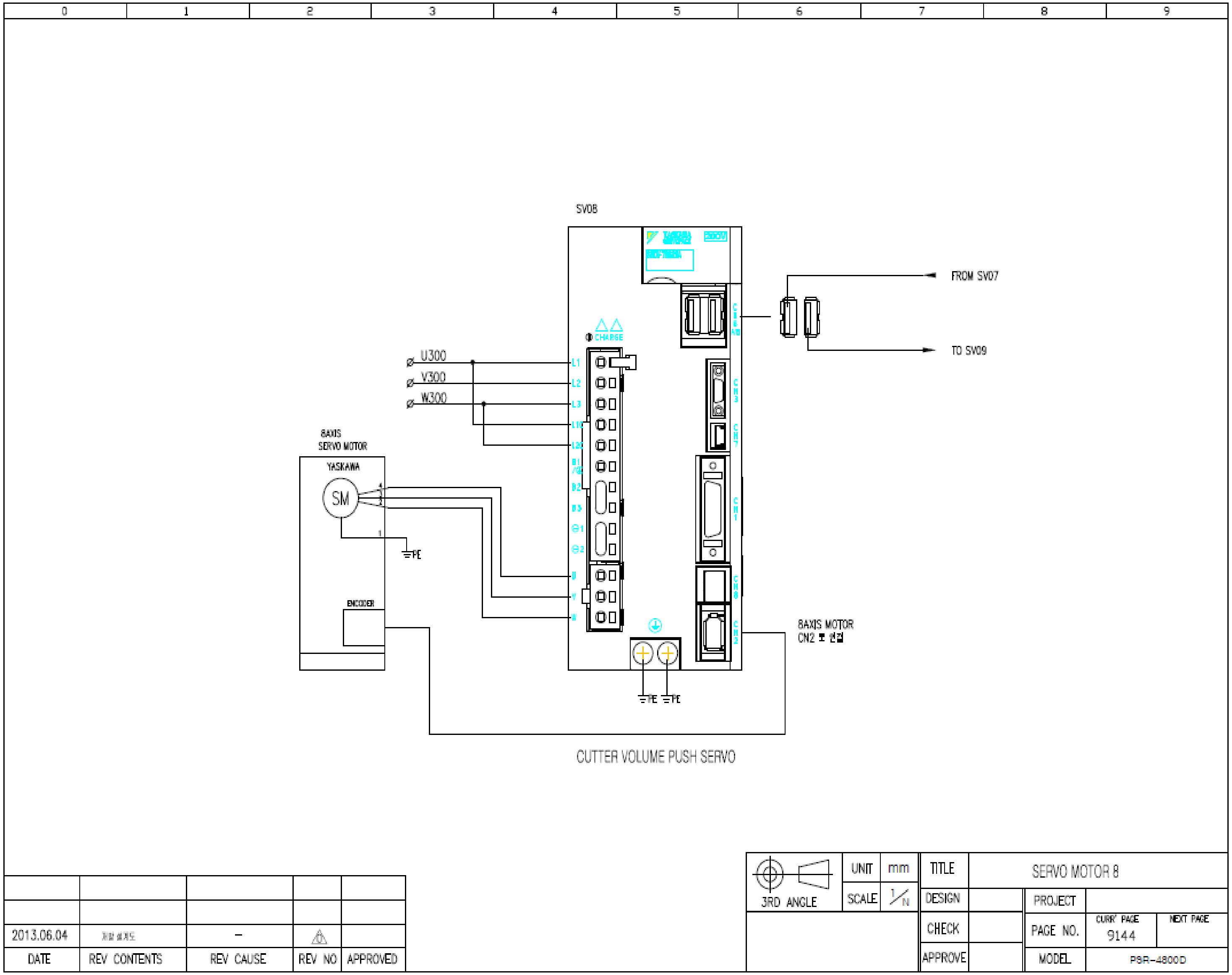
11. Circuit


0
1
2
3
4
5
6
7
8
9
DATE
2013.06.04
REV CONTENTS
개발 설계도
REV CAUSE
-
REV NO
APPROVED
6AXIS
SERVO MOTOR(1500W)
YASKAWA
SM
ENCODER
PE
Ø U300
Ø V300
Ø W300
SV06
W
V
U
⊖2
⊖1
B3
B2
B1/⊕
L2C
L1C
L3
L2
L1
CHARGE
PE
PE
CN2
CN8
CN1
CN7
CN3
CN6 MB
PRESS UPPER SERVO MOTOR
6AXIS MOTOR
CN2 로 연결
TO SV07
FROM SV05
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 6
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9143
NEXT PAGE
9144
MODEL
PSR-4800D

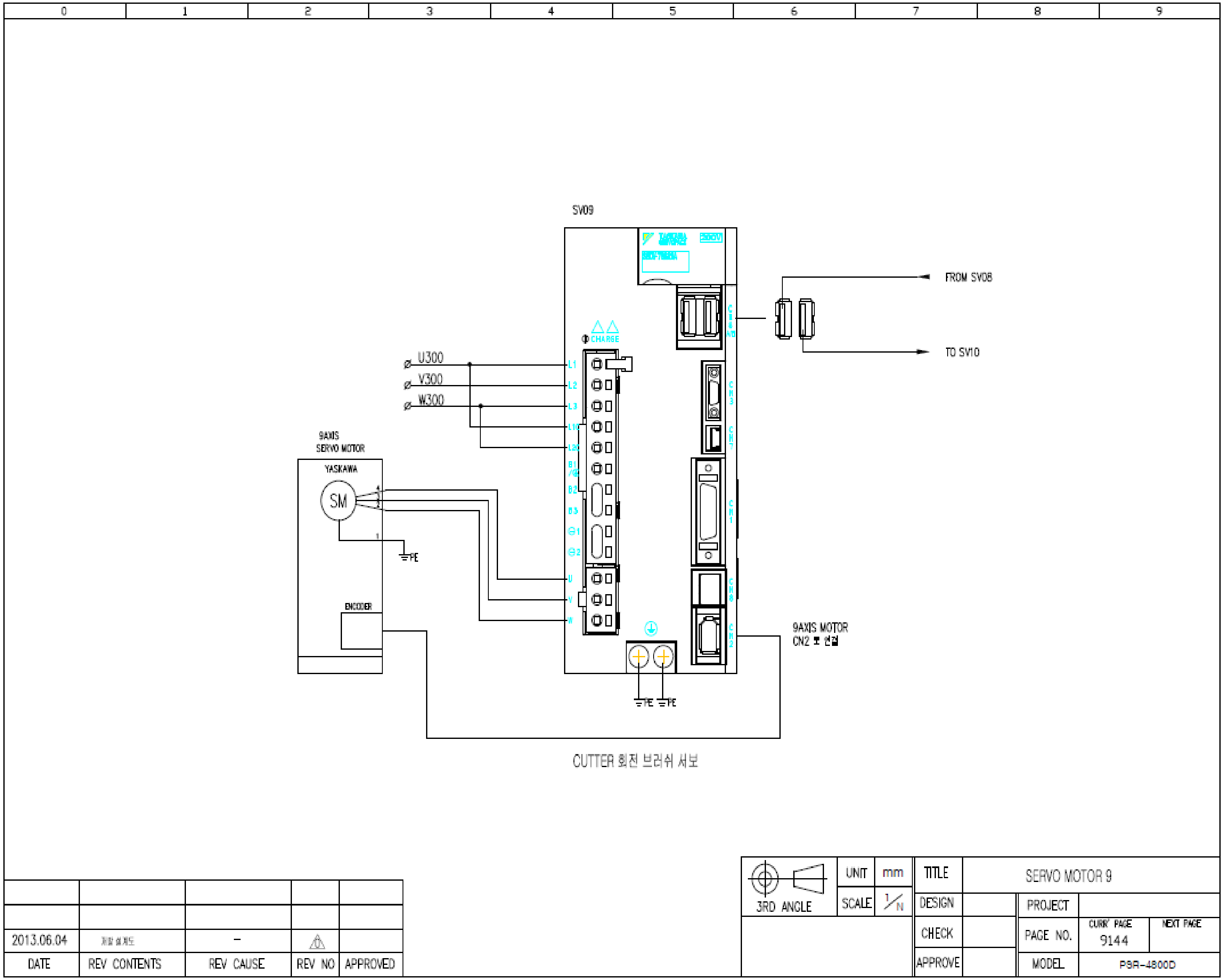
11. Circuit


DATE
2013.06.04
REV CONTENTS
개발 설계도
REV CAUSE
-
REV NO
APPROVED
7AXIS
SERVO MOTOR(1500W)
YASKAWA
SM
ENCODER
1
2
3
4
PE
Ø U300
Ø V300
Ø W300
SV07
W
V
U
⊖2
⊖1
B3
B2
B1/⊕
L2C
L1C
L3
L2
L1
CHARGE
PE
PE
200V
CN2
CN8
CN1
CN7
CN3
CN6A/B
PRESS UNDER SERVO MOTOR
7AXIS MOTOR
CN2 로 연결
FROM SV06
TO SV08
0
1
2
3
4
5
6
7
8
9
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
DESIGN
CHECK
APPROVE
SERVO MOTOR 7
PROJECT
PAGE NO.
CURR' PAGE
9144
NEXT PAGE
MODEL
PSR-4800D

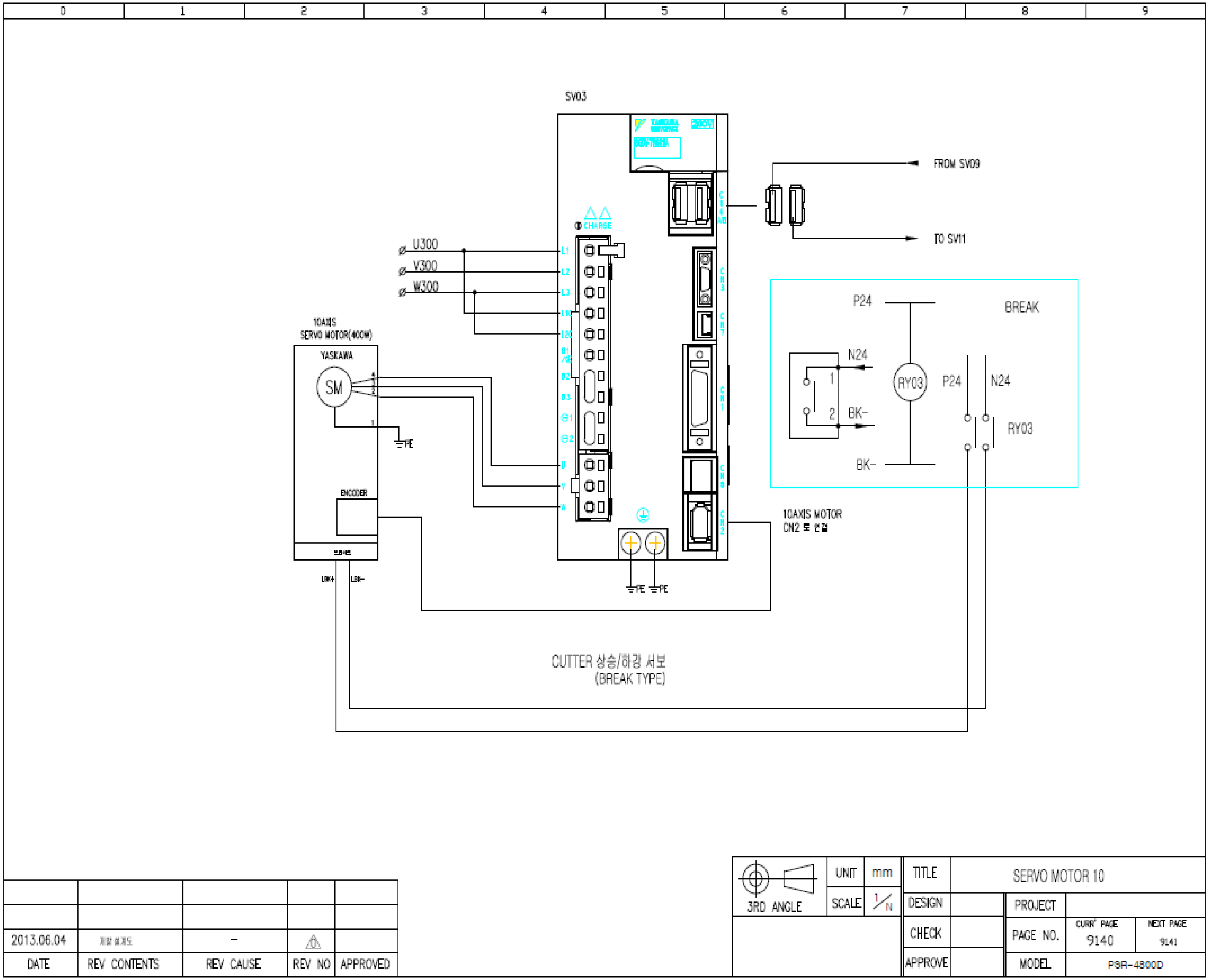
11. Circuit


0
1
2
3
4
5
6
7
8
9
SV08
FROM SV07
TO SV09
U300
V300
W300
8AXIS
SERVO MOTOR
YASKAWA
SM
ENCODER
PE
CHARGE
L1
L2
L3
L1C
L2C
B1
B2
B3
⊖1
⊖2
U
V
W
8AXIS MOTOR
CN2 로 연결
CUTTER VOLUME PUSH SERVO
2013.06.04
–
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 8
DESIGN
PROJECT
CHECK
PAGE NO.
CURR' PAGE
9144
NEXT PAGE
APPROVE
MODEL
PSR-4800D

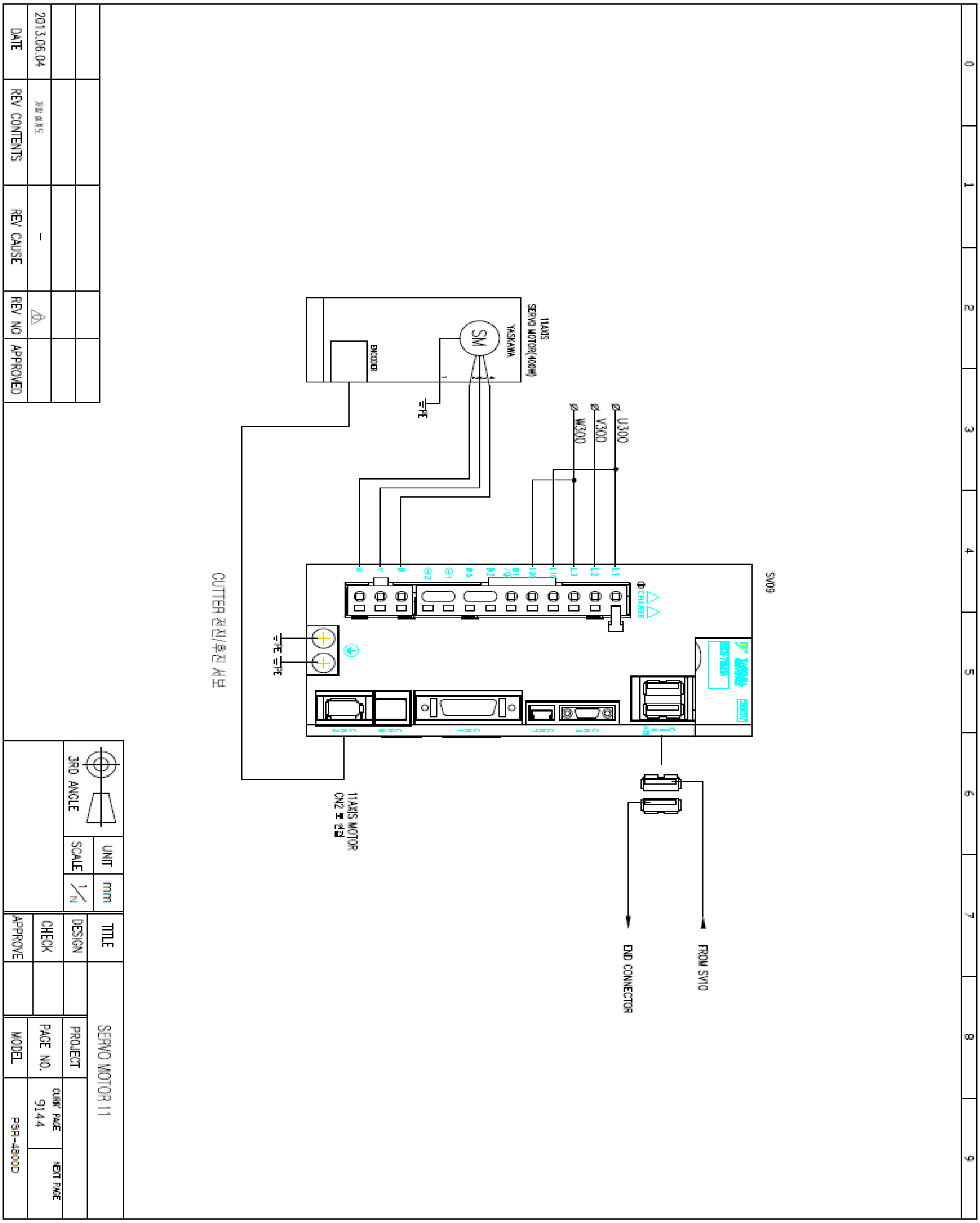
11. Circuit


0
1
2
3
4
5
6
7
8
9
SV09
CHARGE
L1
L2
L3
L1C
L2C
B1/⊕
B2
B3
⊖1
⊖2
U
V
W
CN3
CN7
CN1
CN8
CN2
CN6A/B
U300
V300
W300
9AXIS
SERVO MOTOR
YASKAWA
SM
ENCODER
PE
PE
PE
FROM SV08
TO SV10
9AXIS MOTOR
CN2 로 연결
CUTTER 회전 브러쉬 서보
2013.06.04
개발 설계도
–
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 9
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9144
NEXT PAGE
MODEL
PSR-4800D

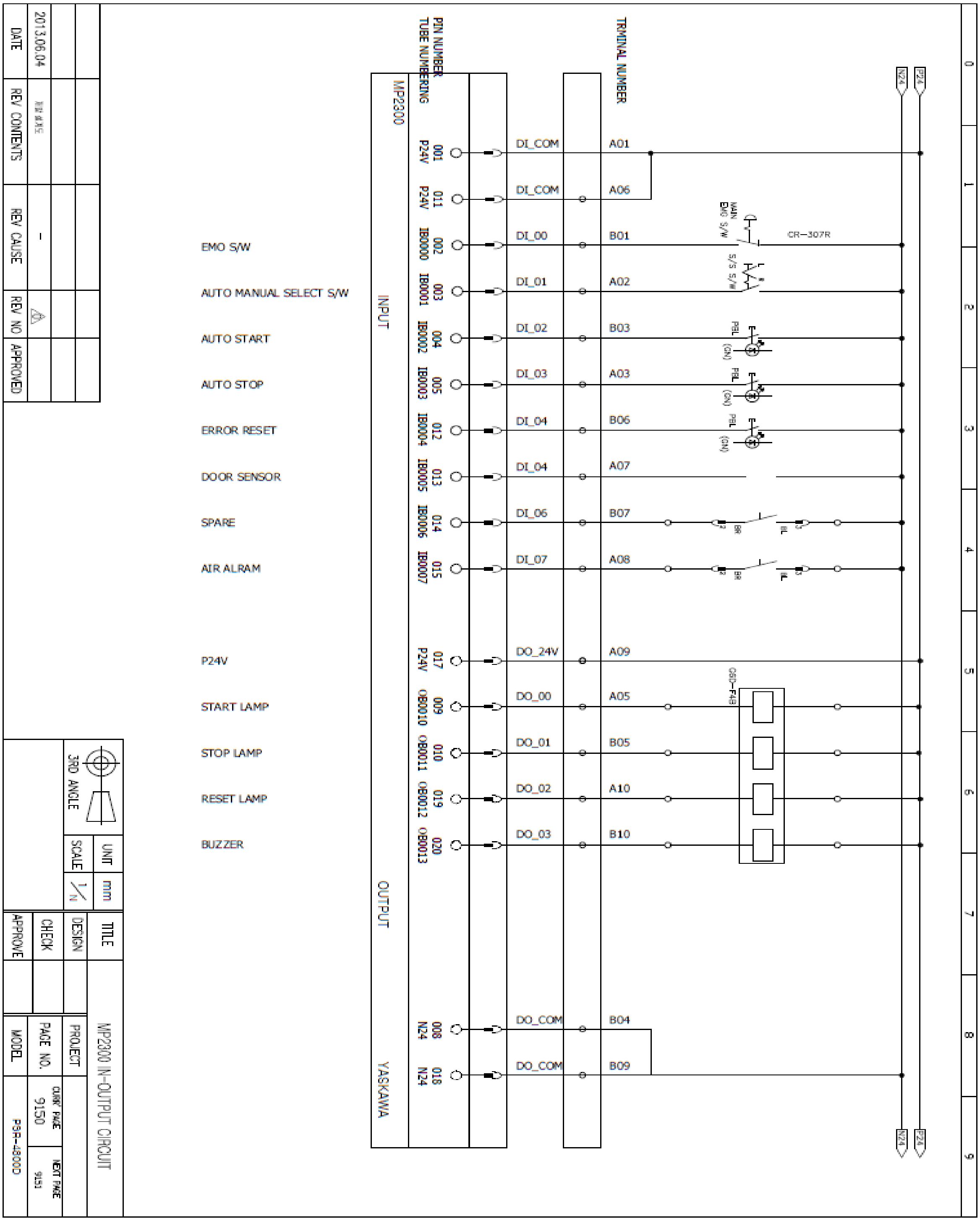
11. Circuit


0
1
2
3
4
5
6
7
8
9
SV03
FROM SV09
TO SV11
CHARGE
U300
V300
W300
L1
L2
L3
L1C
L2C
B1
B2
B3
⊖1
⊖2
U
V
W
10AXIS
SERVO MOTOR(400W)
YASKAWA
SM
ENCODER
PE
PE
PE
P24
BREAK
N24
1
2
BK-
RY03
P24
N24
RY03
BK-
10AXIS MOTOR
CN2 로 연결
CUTTER 상승/하강 서보
(BREAK TYPE)
2013.06.04
DATE
REV CONTENTS
REV CAUSE
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 10
DESIGN
PROJECT
CHECK
PAGE NO.
CURR' PAGE
9140
NEXT PAGE
9141
APPROVE
MODEL
PSR-4800D

11. Circuit

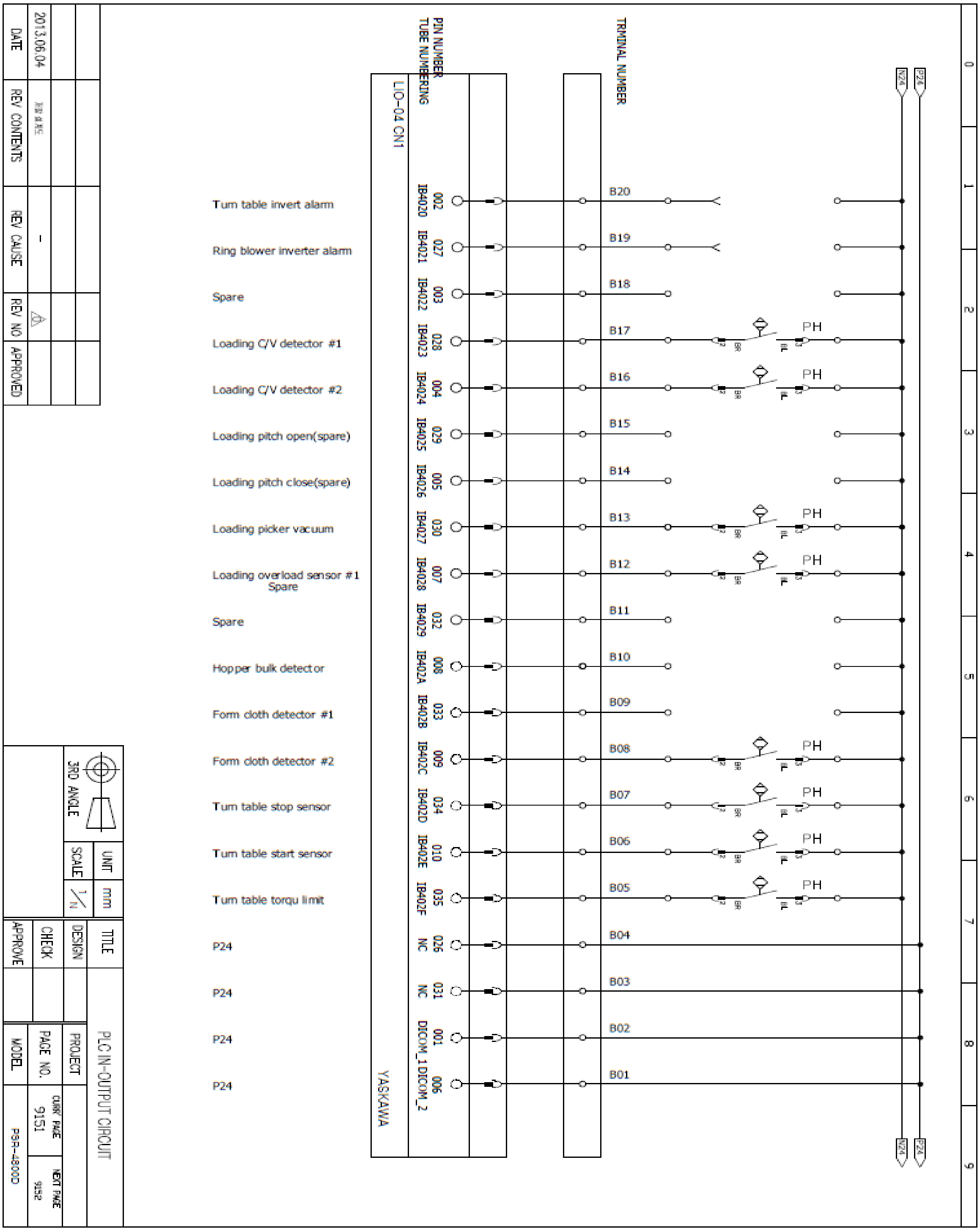

DATE
2013.06.04
REV CONTENTS
REV CAUSE
–
REV NO
APPROVED
11AXIS
SERVO MOTOR(400W)
YASKAWA
SM
ENCODER
PE
U300
V300
W300
SV09
L1
L2
L3
L1C
L2C
B1
B2
B3
U
V
W
CHARGE
PE
CN2
CN8
CN1
CN7
CN3
CN6
CUTTER 전진/후진 서보
11AXIS MOTOR
CN2
FROM SV10
END CONNECTOR
0
1
2
3
4
5
6
7
8
9
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
SERVO MOTOR 11
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9144
NEXT PAGE
MODEL
PSR-4800D

11. Circuit

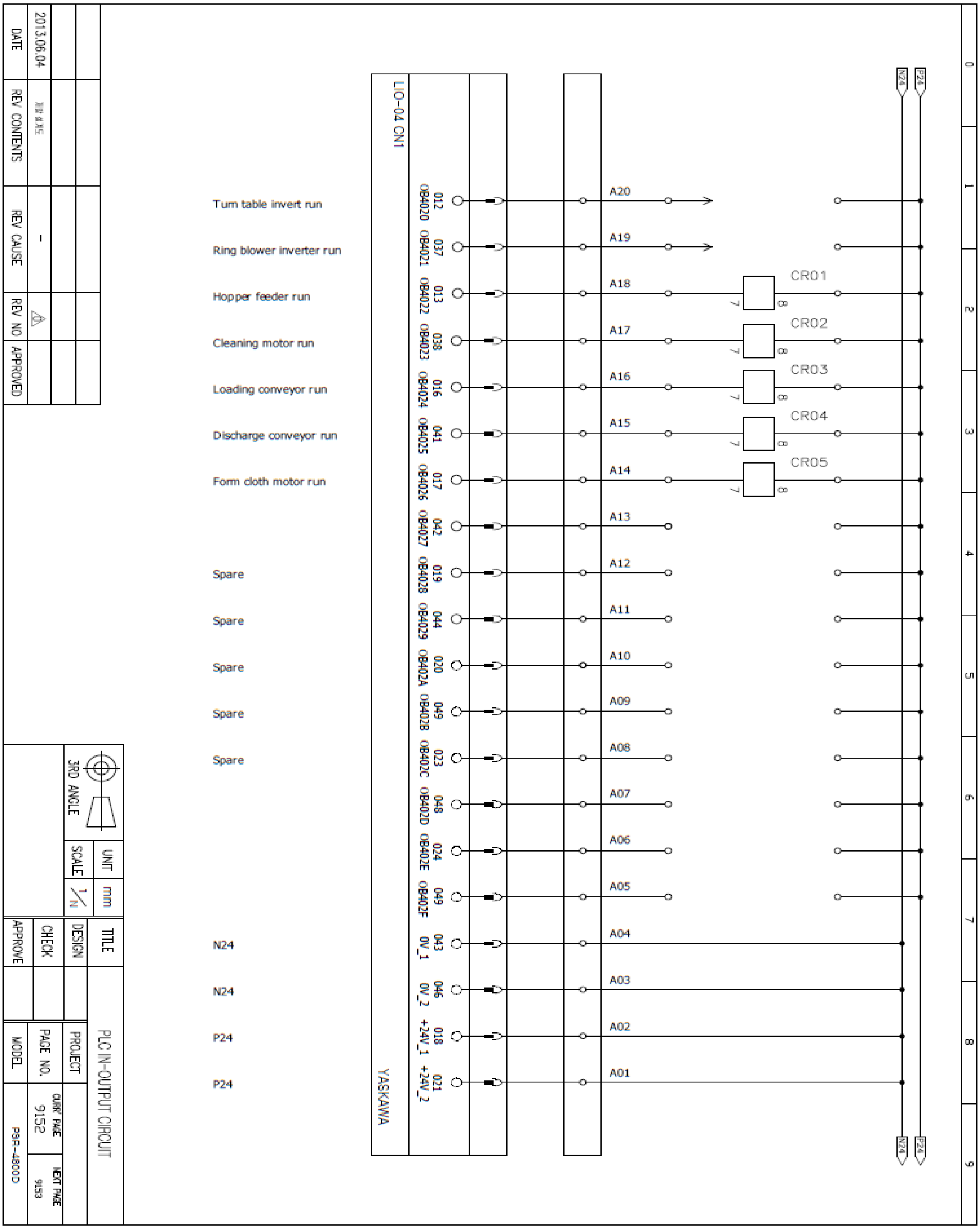


DATE
2013.06.04
REV CONTENTS
REV CAUSE
REV NO
APPROVED
PIN NUMBER
TUBE NUMBERING
TRMINAL NUMBER
MP2300
INPUT
OUTPUT
YASKAWA
P24
N24
EMO S/W
AUTO MANUAL SELECT S/W
AUTO START
AUTO STOP
ERROR RESET
DOOR SENSOR
SPARE
AIR ALRAM
P24V
START LAMP
STOP LAMP
RESET LAMP
BUZZER
001 P24V
011 P24V
002 IB0000
003 IB0001
004 IB0002
005 IB0003
012 IB0004
013 IB0005
014 IB0006
015 IB0007
017 P24V
009 OB0010
010 OB0011
019 OB0012
020 OB0013
008 N24
018 N24
DI_COM
DI_COM
DI_00
DI_01
DI_02
DI_03
DI_04
DI_04
DI_06
DI_07
DO_24V
DO_00
DO_01
DO_02
DO_03
DO_COM
DO_COM
A01
A06
B01
A02
B03
A03
B06
A07
B07
A08
A09
A05
B05
A10
B10
B04
B09
MAIN EMO S/W
CR-307R
S/S S/W
PBL
(GN)
BR
BL
G6D-F4B
0
1
2
3
4
5
6
7
8
9
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
MP2300 IN-OUTPUT CIRCUIT
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9150
NEXT PAGE
9151
MODEL
PSR-4800D

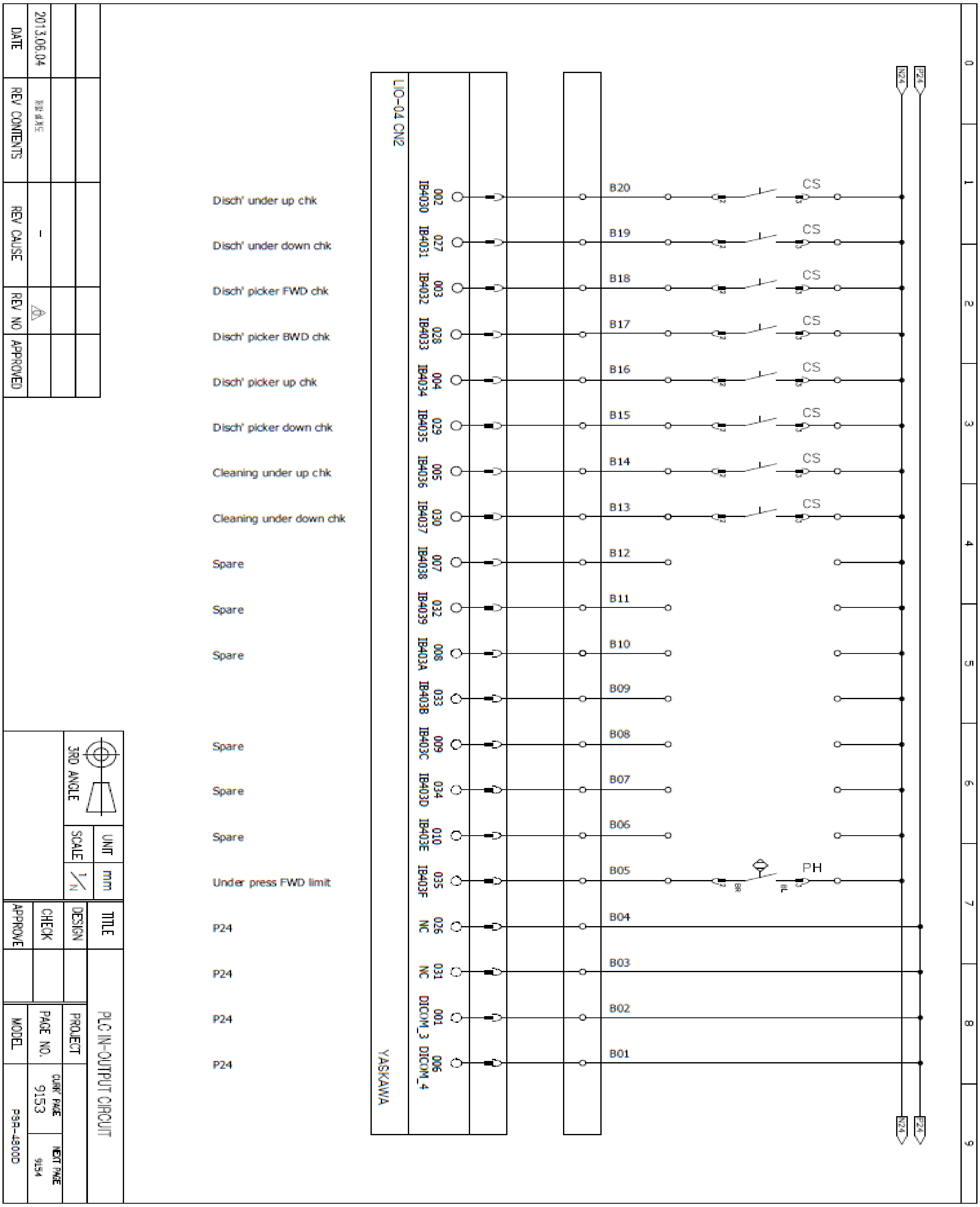
11. Circuit


PIN NUMBER
TUBE NUMBERING
LIO-04 CN1
TRMINAL NUMBER
YASKAWA
P24
N24
Turn table invert alarm
002
IB4020
B20
Ring blower inverter alarm
027
IB4021
B19
Spare
003
IB4022
B18
Loading C/V detector #1
028
IB4023
B17
Loading C/V detector #2
004
IB4024
B16
Loading pitch open(spare)
029
IB4025
B15
Loading pitch close(spare)
005
IB4026
B14
Loading picker vacuum
030
IB4027
B13
Loading overload sensor #1
Spare
007
IB4028
B12
Spare
032
IB4029
B11
Hopper bulk detector
008
IB402A
B10
Form cloth detector #1
033
IB402B
B09
Form cloth detector #2
009
IB402C
B08
Turn table stop sensor
034
IB402D
B07
Turn table start sensor
010
IB402E
B06
Turn table torqu limit
035
IB402F
B05
P24
026
NC
B04
P24
031
NC
B03
P24
001
DICOM_1
B02
P24
006
DICOM_2
B01
PH
BR
BL
0
1
2
3
4
5
6
7
8
9
DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
PLC IN-OUTPUT CIRCUIT
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR PAGE
9151
NEXT PAGE
9152
MODEL
PSR-4800D

11. Circuit


DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
LIO-04 CN1
YASKAWA
Turn table invert run
Ring blower inverter run
Hopper feeder run
Cleaning motor run
Loading conveyor run
Discharge conveyor run
Form cloth motor run
Spare
Spare
Spare
Spare
Spare
N24
N24
P24
P24
012 OB4020
037 OB4021
013 OB4022
038 OB4023
016 OB4024
041 OB4025
017 OB4026
042 OB4027
019 OB4028
044 OB4029
020 OB402A
049 OB402B
023 OB402C
048 OB402D
024 OB402E
049 OB402F
043 0V_1
046 0V_2
018 +24V_1
021 +24V_2
A20
A19
A18
A17
A16
A15
A14
A13
A12
A11
A10
A09
A08
A07
A06
A05
A04
A03
A02
A01
CR01
CR02
CR03
CR04
CR05
7
8
N24
P24
0
1
2
3
4
5
6
7
8
9
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
PLC IN-OUTPUT CIRCUIT
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9152
NEXT PAGE
9153
MODEL
PSR-4800D

11. Circuit


DATE
2013.06.04
REV CONTENTS
REV CAUSE
REV NO
APPROVED
LIO-04 CN2
YASKAWA
Disch' under up chk
Disch' under down chk
Disch' picker FWD chk
Disch' picker BWD chk
Disch' picker up chk
Disch' picker down chk
Cleaning under up chk
Cleaning under down chk
Spare
Spare
Spare
Spare
Spare
Spare
Under press FWD limit
P24
P24
P24
P24
002 IB4030
027 IB4031
003 IB4032
028 IB4033
004 IB4034
029 IB4035
005 IB4036
030 IB4037
007 IB4038
032 IB4039
008 IB403A
033 IB403B
009 IB403C
034 IB403D
010 IB403E
035 IB403F
026 NC
031 NC
001 DICOM_3
006 DICOM_4
B20
B19
B18
B17
B16
B15
B14
B13
B12
B11
B10
B09
B08
B07
B06
B05
B04
B03
B02
B01
CS
CS
CS
CS
CS
CS
CS
CS
PH
N24
P24
N24
P24
0
1
2
3
4
5
6
7
8
9
3RD ANGLE
UNIT
mm
SCALE
1/N
TITLE
PLC IN-OUTPUT CIRCUIT
DESIGN
CHECK
APPROVE
PROJECT
PAGE NO.
CURR' PAGE
9153
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9154
MODEL
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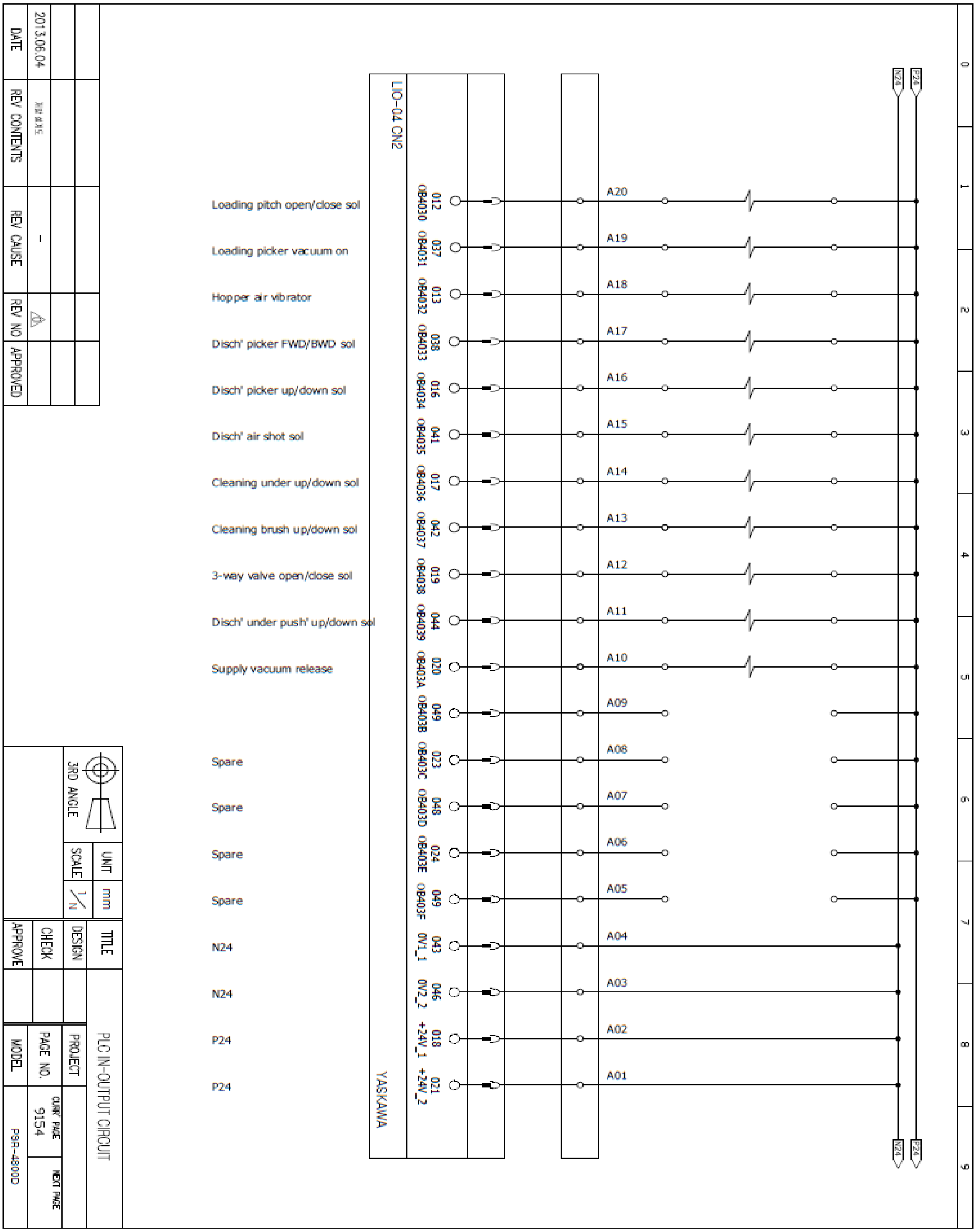
11. Circuit


DATE
2013.06.04
REV CONTENTS
REV CAUSE
-
REV NO
APPROVED
LIO-04 CN2
YASKAWA
Loading pitch open/close sol
Loading picker vacuum on
Hopper air vibrator
Disch' picker FWD/BWD sol
Disch' picker up/down sol
Disch' air shot sol
Cleaning under up/down sol
Cleaning brush up/down sol
3-way valve open/close sol
Disch' under push' up/down sol
Supply vacuum release
Spare
Spare
Spare
Spare
N24
N24
P24
P24
012 OB4030
037 OB4031
013 OB4032
038 OB4033
016 OB4034
041 OB4035
017 OB4036
042 OB4037
019 OB4038
044 OB4039
020 OB403A
049 OB403B
023 OB403C
048 OB403D
024 OB403E
049 OB403F
043 0V1_1
046 0V2_2
018 +24V_1
021 +24V_2
A20
A19
A18
A17
A16
A15
A14
A13
A12
A11
A10
A09
A08
A07
A06
A05
A04
A03
A02
A01
P24
N24
0
1
2
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9
3RD ANGLE
UNIT
mm
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